

## Shielded Metal Arc Welding

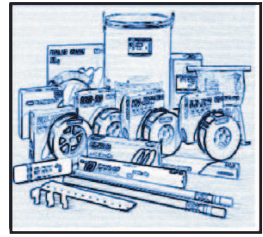
# ANU BOND - 1A H (E 308H - 16)

AWS: SFA 5.4, E308H - 16, IS:5206 E 19.9R 26

### Stainless Steel Electrodes

#### Application

For Welding stainless steels of AISI 308H, 304H, type of base material fabrication works. Used for joining 18/8 stainless when the carbon is in the range of 0.04 - 0.08 %



#### Characteristics on Usage :

It is a rutile coated stainless steel electrode which deposits high carbon i.e. 0.04 to 0.080, 19 Cr, and 10 Ni type of weld metal which give high tensile and creep strength at elevated temperature.

This electrode are used for welding AISI 304H type of base material. It is running with smooth arc with excellent weld bead finish and self lifting slag.

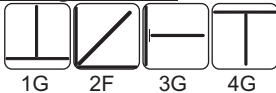
#### Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo	V	Nitrogen
0.04-0.08	0.50-2.00	0.75 Max	0.020	0.030 Max	18.0-21.0	9.0-11.0	0.50 Max	0.50 Max	Absent

#### Mechanical properties of all-weld metal as per AWS

UTS (N/mm <sup>2</sup> )	Elongation (L=4d) %
550 Min	35.0 % Min

#### Welding Positions



#### Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC/ DC (+)	60-90
3.15 x 450	2	12		80-110
4.00 x 350	2	12		100-140
5.00 x 350	2	12		140-180

