


NSB-308H	FOR WELDING AUSTENITIC STAINLESSS STEELS CONTAINING A NOMINAL 19Cr and 10Ni					DATA SHEET NO. 63						
SPECIFICATION	AWS A5.4		BS EN 1600		JIS Z 3221							
CLASSIFICATION	E308H-16		E 19 9 R		D308-16							
PRODUCT DESCRIPTION	<p>A metallurgically advanced rutile based flux formulated with balanced additions of chemically basic, amphoteric and acid minerals, together with small alloy additions to compensate for arc losses.</p> <p>The flux is concentrically extruded onto a fully alloyed core wire and bound by a blend of silicates that assures both coating strength and resistance to subsequent moisture absorption.</p>											
WELDING FEATURES OF THE ELECTRODE	<p>This unique flux formulation ensures excellent arc stability, ease of initial arc strike and re-strike minimal spatter on AC and virtually none on DC+. The resultant weld seams are smooth, evenly rippled and free from undercut while slag detachability is excellent. Metal recovery is some 103% with respect to core wire weight.</p>											
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Applications for the electrode are to be found in the Chemical, Petro-Chemical and Cryogenic Processing and Storage Industries as well as the Food, Brewery and Pharmaceutical Industries using the following materials:</p> <p>ASTM 304 - 304H UNS 53 30409 Cast CF10 - CF8.</p> <p>Particularly valuable in Petro-Chemical plant and Power Generating plant operating in the 400 - 800 °C temperature range as the higher carbon imparts improved creep resistance.</p>											
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe	FN
ALL WELD METAL PROPERTIES	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS							
WELDING AMPERAGE AC or DC+	Ø (mm)	2.0	2.6	3.2	4.0	5.0						
OTHER DATA	Tensile strength	N/mm ²	550	560	HV 190 - 210							
RELATED PRODUCTS	0.2% Proof stress	N/mm ²	-	450						Electrodes that have become damp should be re-dried at 150°C for 1 hour.		
	Elongation on 4d	%	35	45				Please contact our Technical Department for detail.				
	Reduction of Area (RA)	%	-	37								
	Impact energy 20°C	J	-	80								
	MIN	35	65	80	120	160						
	MAX	80	100	125	170	210						