

# EI 308H

Coated Electrode for Stainless Steels -

Standards	
AWS/ASME SFA - 5.4	E308H-16
EN ISO 3581 - A	E 19 9 H R 12
TS EN ISO 3581 - A	E 19 9 H R 12
DIN M. No.	1.4302

**Properties and Applications**

Rutile type austenitic stainless steel electrode for welding especially 304H and similar austenitic stainless steels or cast steels and heat resistant steels, having high carbon content. Suitable for welding stainless steel tanks, valves, pipes and linings in chemical, food, beverage, pharmaceutical, fertilizer industries. Weld metal is suitable for use at high operating temperatures and it is also non-scaling. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easily removable slag.

Typical Chemical Values of Weld Metal					
Type of Analysis	C	Si	Mn	CR	Ni
Weld Deposit	0.06	0.70	1.00	20.00	10.50

Typical Mechanical Values of Weld Metal				
Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	440	600	45	20°C → 60

**Application Information**

Welding Positions: PA, PB, PC, PD, PE, PF

Polarity: = +, ~

Diameter x Length (mm)	Current (A)
2.50x300	50-80
3.25x300	80-110
3.25x350	80-110
4.00x350	100-160

Packaging Information						
Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
13028GJEM2	2.50x300	93 pcs	1.79	9	16.30	VAC Box
13028MJEM2	3.25x300	58 pcs	1.79	9	16.30	VAC Box
13028NJEM2	3.25x350	57 pcs	2.04	9	18.60	VAC Box
13028QJEM2	4.00x350	37 pcs	2.04	9	18.60	VAC Box

**Storage & Re-Drying Information**

It can be dried maximum 5 times.  
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.  
 It has to be dried at 350°C for 2 hours.