



Tech-Rod 308/308H

Description

Tech-Rod 308/308H electrodes are used to weld un-stabilized austenitic stainless steels such as 302, 304 and 305. Tech-Rod 308/308H electrodes provide greater corrosion resistance than the base metals on which they are applied. Typical applications include chemical, petrochemical industries as well as distillery, dairy and restaurant equipment.

Specifications & Approvals

AWS A5.4 E308/308H-16

UNS W30810

ISO 3581:2003 (19 9 H)

CWB

ASME QSC-395

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	N	S	P	Cu	FN
.04-.08	1.65	.52	BAL	19.95		9.95		.050	.02	.02	.04	5

* Nitrogen in these weld deposits is usually between .04% and .08%

Typical Mechanical Properties

Tensile Strength	84,500 PSI	580 MPA
Yield Strength	55,000 PSI	380 MPA
Elongation	40%	

Welding Parameters

Process	Diameter x Length	Voltage	Amperage	
			Flat	Vertical & Overhead
SMAW	3/32" (2.4mm) x 12" (305mm)	24-28	70-85	65-75
	1/8" (3.2mm) x 14" (355mm)	26-30	85-110	80-90
	5/32" (4.0mm) x 14" (355mm)	28-32	110-140	100-120
	3/16" (4.8mm) x 14" (355mm)	28-32	120-160	110-130

Standard Packages:

3/32" Diameter	8 Lb (3.6Kg) Can	24 Lb (10.9Kg) Master Carton	26 Electrodes per Lb
1/8" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	14 Electrodes per Lb
5/32" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	9 Electrodes per Lb
3/16" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	6 Electrodes per Lb