

## Tech-Rod 308/308H

### DESCRIPTION

Tech-Rod 308 / 308H SMAW electrodes are used to weld unstabilized austenitic stainless steels such as AISI 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

**Quality Systems** :

ISO Q9001-2000  
ASME QSC-395

**Specifications** :

AWS/ASME SFA: A5.4 E308-16 / E308H-16

**Approvals**

### TYPICAL CHEMICAL COMPOSITON

Grade	C	Mn	S / P	Si	Cr	Ni	Cu	N	Al
E308-16	.08 Max.	1.65	.02 / .02	0.52	19.95	9.95	0.04	0.050	0.003
E308H-16	.04 - .08	1.65	.02 / .02	0.52	19.95	9.95	0.04	0.050	0.003

### TYPICAL MECHANICAL PROPERTIES of WELD METAL

Tensile Strength	Yield Strength	Elongation 4d
84.5 Ksi	55.0 Ksi	40%
580 Mpa	380 Mpa	

### WELDING PARAMETERS

Process	Electrical	Amperage
<u>SMAW</u>	DCEP	.093" (2.50mm) 65-75
		.125" (3.14mm) 90-105
		.156" (4.00mm) 120-135
		.187" (4.00mm) 135-155

[For vertical welding, amperage should be reduced by 10 - 15 amps]