

ROYAL - 1A H (E 308H - 16)

AWS : SFA 5.4, E 308H - 16

IS : 5206 E 19.9R 26

Applications

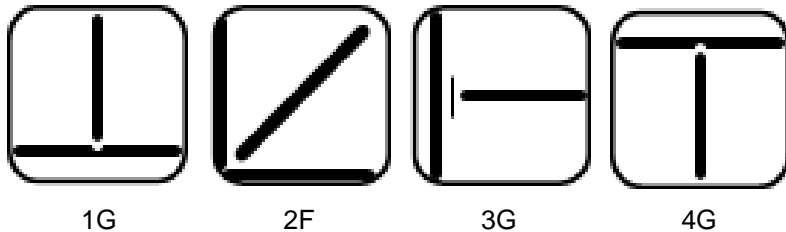
for welding stainless steels of AISI 308H, 304H, type of base material fabrication works. Used for joining 18/8 stainless steel when the carbon is in the range of 0.04 – 0.08 %.

Characteristics on Usage

It is a rutile coated stainless steel electrode which deposits high carbon i.e. 0.04 to 0.080, 19Cr, and 10 Ni type of weld metal which gives 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.

Notes On Usage

- ✍ 1) Dry the electrode a 350°C for 60 Min- before use .
- ✍ 2) Remove dirt such as oil and dust from the groove .
- ✍ 3) Keep the arc as short as possible.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
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

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550 Min	35.0 % Min

Approvals

IOCL

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / DC (+)	60 – 90
3.15 x 350	2	10		80 – 110
4.00 x 350	2	10		100 – 140
5.00 x 350	2	10		140 – 180

Packing

Vaccum packing