

NC-308H

For welding of 18%Cr-8%Ni stainless steel

AWS A5.4 E308H-16
KS D 7014 E308-16
JIS Z3221 ES308H-16

Applications

Welding of 18%Cr-8%Ni stainless steel such as AISI (SUS) 304, 308H.

Characteristics

NC-308H is a lime-titania type electrode for all-position welding. It's Carbon content in weld metal is controlled 0.04%~0.08%, so its tensile strength & creep strength are good in the as welded conditions.

Notes on usage

- (1) Keep the arc as short as possible and choose the welding current as low as possible.
- (2) Weaving width should be within two and a half times of electrode's diameter.
- (3) When the electrodes have absorbed moisture, dry them at 250~300°C for 60~90 minutes before use.
- (4) Usually, preheat is not necessary.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Ni
0.07	1.05	0.70	0.019	0.006	19.65	9.85

Typical mechanical properties of weld metal

TS N/mm ² (kgf/mm ²)	EL %
610(62)	45.0

Size & recommended current range(DC±)

Dia. (mm)	2.6	3.2	4.0	5.0	
L (mm)	300	350	350	350	
Amp.	F	50-80	70-115	100-150	150-200
	V&OH	65-110	95-140	-	-

• Tip Color : Blue