

# RATNA 308H

An electrode specially designed for producing 19Cr-10Ni weld deposit with carbon 0.04- 0.08%,

**CLASSIFICATION** : AWS/SFA-5.4: E 308H-16  
IS-5206: E 19.9R 26

**APPROVAL** :

**CHARACTERISTICS** : An electrode specially designed for producing 19Cr-10Ni weld deposit with carbon 0.04- 0.08%, weld metal is resistant to crack and exhibits excellent mechanical properties at elevated temperature. The weld produced are of radiographic quality with smooth bead finish.

**APPLICATION** :

- 1) Suitable for joining AISI 304H material used in high temperature applications (730°C).
- 2) Ideally suitable for joining 18/8 SS consisting of higher carbon percentage.
- 3) **Chemical, petrochemical and refinery equipments.**

**RE-DRY CONDITION** : Re-Dry the electrode at 250°C for 1 hrs before use.

## ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni
0.04-0.08	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	18.00-21.00	9.00-11.00

## ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +20 <sup>0</sup> C : 60-80 J	FERRITE (FN)
550-660	35-45		3-10

## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC-/AC) Amps	kg./pkt.	kg./Case
2.00 X 300	5/ 64" X 12"	40-60	1.5	15
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	75-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	150-180	2	20

Customer packing on request.