

# S-308H.16

AWS A5.4 / ASME SFA5.4 E308H-16

TYPE : Rutile

SMW

## Applications

Welding of ASTM 304H, 304 stainless steel.

## Characteristics on Usage

S-308H.16 is a lime-titania type electrode and has a good creep resistance.

Advantage for applications with service temperatures up to 700°C(1292°F).

Ferrite content of 3~8FN.

The slag removability and welded metal appearance are good.

## Notes on Usage

- ① Dry the electrodes at 350°C(662°F) for 60 minutes before use.
- ② Keep the current as low as possible and length as short as possible.
- ③ Remove rust, water, oil and paint from the groove.

## Welding Position

## Current



1G 2F 3G 4G  
(PA) (PB) (PF) (PE)

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.050	0.65	0.9	0.03	0.02	18.90	9.90

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)	CVN-Impact Value J (ft · lbs) 20°C (68°F) -40°C (-40°F)	
590 (85,500)	41	60 (44)	50 (37)

## Approval

## Packing

Packet 2.5 kg (5.5 lbs)  
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	350 (14)	350 (14)	350 (14)
F	50~85	70~120	95~150	145~200
V-up, OH	45~80	65~115	85~135	-