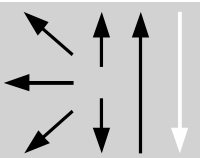


Classifications						
EN ISO 17633-A		EN ISO 17633-B			AWS A5.22	
T Z 19 9 H P M21/C1 1		TS 308H-F M21/C1 1			E308HT1-4/1	
Characteristics and typical fields of application						
<p>Rutile flux-cored wire of T Z 19 9 H P / E308HT1 type for welding of CrNi austenitic stainless steels such as EN 1.4948 / AISI 304H for elevated service temperatures. The higher carbon content, compared to E308LT1, provides improved creep resistance properties, which is advantageous at temperatures above 400°C. Max. temperature according to the TÜV approval is 700°C. The corrosion resistance is corresponding to EN 1.4301 / ASTM 304, i.e. good resistance to general corrosion. The enhanced carbon content, compared to 308L, makes it slightly more sensitive to intergranular corrosion. The fast freezing slag offers excellent weldability and slag control in all positions. Easy handling and high deposition rate result in high productivity with excellent welding performance and very low spatter formation. Increased travel speeds as well as self-releasing slag with little demand for cleaning and pickling provide considerable savings in time and money. The wide arc ensures even penetration and side-wall fusion to prevent lack of fusion. The very low bismuth content of ≤ 10 ppm results in excellent elongation and impact toughness also after service at elevated temperatures. The controlled ferrite content of 3 – 8 FN (measured with Fischer Feritescope) offers good resistance to hot cracking and sigma phase embrittlement. For flat and horizontal welding positions (1G, 1F and 2F) BÖHLER E 308 H-FD may be preferred.</p>						
Base materials						
EN 1.4301 X5CrNi18-10, 1.4541 X6CrNiTi18-10, 1.4550 X6CrNiNb18-10, 1.4878 X8CrNiTi18-10, 1.4948 X7CrNi18-9 ; UNS S30400, S30409, S32100, S34700; AISI 304, 304H, 321, 321H, 347, 347H						
Typical analysis of all weld metal						Ferrite WRC-92
	C	Si	Mn	Cr	Ni	FN
wt.-%	0.05	0.6	1.2	19.4	10.1	2 – 8
Mechanical properties of all-weld metal – typical values (minimum values)						
Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	20°C		
u	370 (≥ 350)	560 (≥ 550)	45 (≥ 30)	90 (≥ 32)		
u untreated, as-welded – shielding gas Ar + 18 % CO ₂						
Operating data						
	Ø (mm)	Wire feed m/min	Arc length mm	Current A	Voltage V	
	1.2	6.0 – 13.0	~ 3	150 – 230	22 – 29	
<p>Welding with standard GMAW power source with DC+ polarity. No pulsing needed. Backhand (drag) technique preferred with a work angle of appr. 80°. Ar + 15 – 25 % CO₂ as shielding gas offers the best weldability. 100 % CO₂ can be also used, but the voltage should be increased by 2 V. The gas flow should be 15 – 18 l/min. The heat input should not exceed 2.0 kJ/mm, the interpass temperature be limited to max. 150°C and the wire stick-out 15 – 20 mm. Re-drying of the wire possible at 150°C for 24 h if necessary. The scaling temperature is approx. 850°C in air. Post-weld heat treatment generally not needed. In special cases, solution annealing can be performed at 1050°C followed by water quenching.</p>						
Approvals						
TÜV (11151.), CE						