

Classifications

EN ISO 3581-A

AWS A5.4

E Z18 16 1 Cu H B 2 2

E308H-15 (mod.)

Characteristics and typical fields of application

Basic alloyed electrode for joining and surfacing on matching austenitic creep resistant CrNi(N)- steels/ cast steel grades with good high temperature corrosion resistance. Stainless

Base materials

1.4907 X10CrNiCuNb18-9-3

18Cr-9Ni-3Cu-Nb-N; ASME SA-213; code case 2328-1

and comparable creep resistant, austenitic steels, Super 304 H, DMV 304 HCu

Typical analysis of all-weld metal (wt.-%)

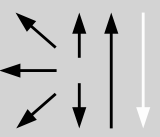
	C	Si	Mn	Cr	Ni	Mo	Nb	Cu	N
wt.-%	0.1	0.4	3.2	18.0	16.0	0.8	0.4	3.0	0.2

Mechanical properties of all-weld metal

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	≥ 350	≥ 590	≥ 25	≥ 32

u untreated, as welded

Operating data

	Polarity:	Electrode identification:	ø (mm)	L mm	Amps A
	DC (+)	FOX E 304 H Cu E Z18 16 1 Cu H B	2.5 3.2	350 350	45 – 70 65 – 110

Preheating is not required.

Solution annealing at 1100 °C is possible