

Classifications					
EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	Mat. No.		
G 19 9 H	SS19-10H	ER19-10 H	1.4948		
Characteristics and typical fields of application					
High temperature resistant up to 700 °C (1292 °F); resistant to scaling up to 800 °C (1472 °F). For surfacing and joining applications on matching / similar high temperature resistant steels / cast steel grades.					
Base materials					
1.4550 – X6CrNiNb18-10		1.4948 – X6CrNi18-1			
1.4878 – X12CrNiTi18-9		AISI 304H; 321H; 347H			
Typical analysis of solid wire (wt.-%)					
	C	Si	Mn	Cr	Ni
wt-%	0.05	0.3	1.8	18.8	9.3
<b>Structure:</b> Austenite with approx. 5 % ferrite					
Mechanical properties of all-weld metal					
Heat-treatment	Yield strength R <sub>p0.2</sub>	Yield strength R <sub>p1.0</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	MPa	%	+20 °C
aw	350	370	550	35	70
<b>Creep rupture properties:</b> In the range of matching high temperature resistant parent metals					
Operating data					
<b>Polarity:</b> DC ( + )	<b>Shielding gas:</b> (EN ISO 14175) M12		<b>ø (mm)</b> 0.8 1.0 1.2	<b>Spool:</b> B300 B300 B300	
Welding instruction					
Materials	Preheating		Postweld heat treatment		
Matching / similar steels/ cast steel grades	Up to 25 mm wall thickness: none. Over 25 mm wallthickness: max. 200 °C (392 °F) advisable		Up to 25 mm wall thickness: none. Over 25 mm wall thickness: to avoid stress corrosion cracking 1050 °C (1922 °F) / air		
Approvals					
TÜV (06522), CE					