WELDWIRE COMPANY, INC. **Technical Information**

Stainless Steel Electrodes

Alloy: WW308H-16 Class: E308H-16

Conforms to Certification: AWS A5.4 ASME SFA A5.4

Alloy: E308H-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.04 - 0.08	Si = 1.00 max
Cr = 18.0 - 21.0	P = 0.04 max
Ni = 9.0 - 11.0	S = 0.03 max
Mo = 0.75 max	Cu = 0.75 max
Mn = 0.5 - 2.5	

Deposited All Weld Metal Properties %
(Typical) As-Welded

Yield Strength	86,000psi
Tensile Strength	57,000psi
Elongation	39%

Deposited Chemical Composition % (Typical)

C = 0.05	Si = 0.42
Cr = 19.20	P = 0.01
Ni = 10.30	S = 0.01
Mn = 1.75	Mo = 0.27

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

Diameter	Voltage	Amperage Flat Position	Amperage Vertical & Overhead
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130

Application

E308H-16 electrodes can be used in all the applications specified for type E308-16. In addition it can be used to weld type 304H and similar applications where creep strength is required.

If additional information is needed Contact Weldwire Company, Inc. 800-523-1266