

# ES 308H-15

Type Basic

SMAW  
E308H-15

**ESWECO**  
*The Art of Welding*

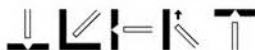
## Description

ES 308H-15 is a basic coated, stainless-steel electrode of the 308H type. The electrode is designed for high-temperature applications in petrochemical and chemical process plants.

ES 308H-15 is widely used in petrochemical and chemical process plant, particularly for the fabrication of cyclones, transfer lines operating in the range 400-815°C.

## Current

DC+



## Classifications

EN 1600	E 19 9 H B 2 2
SFA/AWS A5.4	E308H-15

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.07	0.5	1.5	19.0	10.0	<0.5	<0.5

## Typical mech. Properties all weld metal

Yield stress, MPa	430
Tensile strength, MPa	600
Elongation A4, %	45

## Charpy V

Test temps, °C	Impact values, J
+20	96

Ferrite content	FN 2-5
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## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	55-85	23
3.2	350	75-110	24
4.0	350	110-155	24