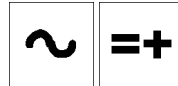


Coating type:
Rutile

Current:



Welding positions:



Hilchrome 308R is our rutile coated electrode for welding low carbon 18Cr10Ni austenitic stainless steel grades like AISI 304, 304L. Typical applications include all industries where similar materials (incl. higher carbon types) as well as ferritic 13% Cr steels are used. Hilchrome 308R is also suitable for Nb (Cb) or Ti stabilised grades 347 and 321. Weld metal has an excellent resistance to general and intergranular corrosion (up to 350°C), good resistance to oxidising acids and cold reducing acids. Hilchrome 308R is a core wire alloyed all-current type (AC/DC).

Base materials to be welded:

- ASTM/AISI Grade 302, 304, 304L, 304LN, 321, 347
- WNr 1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4300
- CrNi 18 10 and similar stainless steel grades

Applications:

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction
- Repair & Maintenance
- Process Industry

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni
0,03	0,8	0,8	≤ 0,025	≤ 0,030	19,8	10,2

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 350	≥ 520	≥ 35	+20°C ≥ 47 -196°C ≥ 32

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,0	300	11,3	40-60
2,5	300	17,5	50-90
3,2	350	33,3	80-120
4,0	350	50,6	110-160