

Classifications			
EN ISO Norm A	EN ISO Classification A	AWS/SFA Norm A	AWS/SFA Classification A
EN ISO 3581-A	E 19 9 H R 4 2	AWS A5.4 / SFA-5.4	E308H-16
Characteristics and typical fields of application			
Short Description	Key Features	Typical Applications	
Rutile-basic coated electrode of E 19 9 H R / E308H-16 type for welding of creep resistant CrNi-alloyed austenitic stainless steels such as 1.4948 / 304H. Controlled ferrite content of 3 – 8 FN. The deposit is resistant to embrittlement and scaling. Service temperatures up to 700°C. Excellent weldability in all positions except vertical down.	For high temperature, creep resistant austenitic steels. Resistant to embrittlement. Service temperature up to 700°C. Ferrite: 3-8 FN	Creep resistant CrNi austenitic steels. Chemical and petrochemical industry Boiler, reactor or turbine components.	
Typical analysis (Chemical Composition)			
C	Si	Mn	Ni
0.05 %	0.6 %	0.8 %	10.2 %
Cr			
19.8 %			
Mechanical Properties - Condition 1			
Condition	Yield Strength Re	Tensile Strength Rm	Elongation A (L0=5d0)
u	420 (>= 350) MPa	580 (>= 550) MPa	40 (>= 30) %
Temperature 1	Impact value 1 ISO-V KV	Footnote	
20 °C	70 (>= 32) J	u: untreated, as welded	
Operating Data			
Welding Position (ISO/ASME)	Current Polarity		
Third_Pictogram	AC / DC+		
Technical Details			
Electrode Identification	Re-Drying		
FOX E 308 H-16 E 19 9 H R	120-200°C/2h		
Approvals			
CE			
X			
Details welding consumables			
CE	CLASS AWS	CLASS EN ISO	NORM AWS
X	E308H-16	E 19 9 H R 4 2	AWS A5.4 / SFA-5.4
NORM EN ISO	TÜV		
EN ISO 3581-A	X		