



**WA. ALLOY CO.**

WASHINGTON ALLOY'S Quality Management System is Certified to **ISO 9001:2008** Cert # 05-R0925

# USA 308H-16 Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



**American Welding Society**  
Sustaining Company Member



## ALLOY DESCRIPTION AND APPLICATION;

USA 308H electrodes contain higher carbon over 308 for the welding of austenitic, high carbon 18% Cr – 8% Ni stainless steels such as AISI-304-H. The weld deposit of this electrode contains a 0.04 - 0.08% carbon, which provides higher tensile and creep strengths at elevated temperatures. USA 308H electrodes have a high deposition rate resulting in excellent efficiency. This electrode may be used in all positions. USA 308H electrodes may be used joint welds in construction parts for chemical engineering and cryogenic applications.

## TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps	Diameter	Amps
1/16"	15-40	1/8"	75-110
5/64"	30-50	5/32"	100-140
3/32"	50-75	3/16"	160-200

Arc Length = short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.  
When welding vertical reduce amperage 10-20%

## TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.05		
Manganese	0.75	Phosphorus	0.028
Silicon	0.35	Sulfur	0.025
Chromium	19.74	Nickel	9.92
	Elongation		44%
	Yield Strength (psi)		68,000
	Tensile Strength (psi)		89,000

Iron balance and all single values are maximum percentages

**AVAILABLE SIZES:** TF308H-16 = 1.8"

**SPECIFICATIONS;** ANSI/AWS A5.4 E308H-16  
ASME SFA 5.4 E308H-16



**EAST COAST**  
7010-G Reames Rd  
Charlotte, NC 28216  
Tel (888) 522-8296  
Fax (704)598-6673

**GULF COAST**  
4755 Alpine Drive #100A  
Stafford, TX 77477  
Tel (877) 711-9274  
Fax (281)313-6332

**WEST COAST**  
8535 Utica Ave  
Rancho Cucamonga, CA 91730  
Tel(800)830-9033  
Fax (909)291-4586

Warehouse Distribution Center – Dayton, Ohio

Head Office – Puyallup, Washington

Washington Alloy Company believes that all information and data given is correct. Use this information to assist in making your own evaluations or decisions and this information should not be mistaken as an expressed or implied warranty. U.S. ALLOY CO. assumes no liability for results or damages incurred from the use of any information contained herein, in whole or in part.