

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY308HT

### ● Applicable Specification

JIS Z 3221 ES308H-16  
AWS A5.4 E308H-16

### ● Identification Color

End Face: Yellow  
Side Face: White

### ● Applications and Characteristics

TASETO RNY308HT is the electrode developed with the objective to limit the ferrite content of all weld metal to 3~8% and improving the mechanical properties at elevated temperatures. It is used for welding of Type 304H for high temperature service. Crack resistibility of its weld metal is good.

RNY308HT is a lime-titania type covered electrode suitable for positional welding.

### ● Notes on Usage

\* Dry the electrode at 150°C to 200°C for 60 minutes before use.

\* Remove oil and dust from the surface to be welded.

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.050	0.49	1.58	0.027	0.005	10.14	19.53	0.07	0.12

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	440	584	41.0

### ● Typical Mechanical Properties of All Weld Metal in Elevated Temperatures

Temperature (°C)	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
550	239	372	28.7
650	211	271	29.3
700	181	231	43.3
750	152	189	61.7

### ● Typical Creep Rupture Strength (700°C, MPa)

1,000h	5,000h	10,000h
94	71	63

### ● Other Properties of All Weld Metal

Typical Ferrite Content : 4.5% (DeLong's Diagram)

### ● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—