# NC-38H PREMIARC™

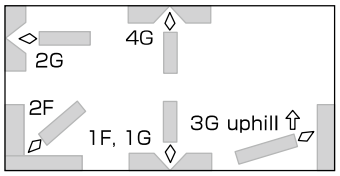
**Stick electrode**

**Features:**
- Applicable for 304 type steel for high temperature
- Excellent mechanical properties at high temperatures

**Classification:** AWS A5.4 E308H-16

**Redrying Conditions:** 150~200℃x0.5~1h
**Identification color:** 1st Yellow
**Polarity:** AC, DCEP

**Welding Positions:**




## Packaging data

| ϕ mm | Length mm | kg/pack | kg/carton | g/piece | carton mm |
|---|---|---|---|---|---|
| 2.6 | 300 | 2 | 20 | 20 | 300W, 100H, 330L |
| 3.2 | 350 | 5 | 20 | 36 | 175W, 125H, 380L |
| 4.0 | 350 | 5 | 20 | 54 | 175W, 125H, 380L |
| 5.0 | 350 | 5 | 20 | 80 | 175W, 130H, 380L |

## Composition (all-weld metal mass%)

| | Typical (AC) | Guaranty [a] |
|---|---|---|
| **C** | 0.06 | 0.04~0.08 |
| **Si** | 0.45 | 1.00 |
| **Mn** | 1.95 | 0.5~2.5 |
| **P** | 0.02 | 0.04 |
| **S** | <0.01 | 0.03 |
| **Ni** | 9.5 | 9.0~11.0 |
| **Cr** | 19.5 | 18.0~21.0 |
| **Mo** | 0.05 | 0.75 |
| **Cu** | 0.07 | 0.75 |

Note: [a] Single values are maximum.

## Welding parameters (A)

| ϕ mm | 1F, 1G, 2F, 2G | 3G uphill, 4G |
|---|---|---|
| 2.6 | 50~85 | 45~80 |
| 3.2 | 70~115 | 65~110 |
| 4.0 | 95~145 | 85~135 |
| 5.0 | 135~180 | - |

## All-weld mechanical properties

| | Typical (AC) | Guaranty |
|---|---|---|
| **0.2%YS (MPa)** | 403 | - |
| **TS (MPa)** | 572 | 552min. |
| **El on 4d (%)** | 48 | 30min. |
| **IV 0℃ (J)** | 79 | - |