

Classifications					
EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	Mat. No.		
W 19 9 H	SS19-10H	ER19-10H	1.4948		
Characteristics and typical fields of application					
High temperature resistant up to 700 °C (1292 °F); resistant to scaling up to 800 °C (1472 °F). For surfacing and joining applications on matching / similar high temperature resistant steels / cast steel grades.					
Base materials					
TÜV-certified parent metal 1.4948 – X6CrNi18-11, 1.4878 – X12CrNiTi18-9, 1.4850 – X6CrNiNb18-10, AISI 304H, 321H, 347H					
Typical analysis of the TIG rods (wt.-%)					
	C	Si	Mn	Cr	Ni
wt-%	0.05	0.4	1.8	18.8	9.3
Structure: Austenite with part ferrite, 5 % max.					
Mechanical properties of all-weld metal					
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	MPa	%	+20 °C
aw	400	430	600	30	100
Creep rupture properties: In the range of matching high temperature resistant parent metals					
Operating data					
Stromart:	Schutzgas:	Kennzeichnung:		ø (mm)	L mm
DC (–)	(EN ISO 14175) I 1	✦ W 19 9 H / ER19-10 H		1.0	1000
				1.6	1000
				2.0	1000
				2.4	1000
				3.2	1000
Welding instruction					
Materials	Preheating	Postweld heat treatment			
Matching / similar steels / cast steel grades	None	None. To avoid stress corrosion cracking: 1050 °C (1922 °F) / air			
Approvals					
TÜV (01616), GL					