Selectarc Inox 16-8-2B

Basic type Stainless steel
Electrode with increased carbon

Classification

AWS A5.4 : E16-8-2-15
ISO 3581-A : E 16 8 2 B 4 2
EN 1600 : E 16 8 2 B 4 2

Description & Applications

Austenitic stainless steel electrode, basic type coating with approx. 5% ferrite and increased carbon contend. Stable arc, good slag removal, regular weld bead. Good behavior in positional welding and on bad prepared joints. Excellent mechanical properties. Used on 18/8 stainless steels (304H type) and 17-12-2 stainless steels (316H type) as well as for stabilized grades, applied for elevated service temperatures up to +750°C.

Main applications: For petrochemical industry: tubes, heat exchangers, piping systems.

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088 / 10269	Material N°
S30400	304	X5CrNi 18-10	1.4301
S30409	304H	X6CrNi 18-11	1.4948
S31600	316	X5CrNi17-12-2	1.4401
	316H	X6CrNiMo17-13	1.4919
		G-X6CrNi18-10	1.6902

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
0.05	0.4	1.8	16.0	9.0	1.7	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>380	>560	>35	+20°C >60

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	90	120

Redrying 1h at 250°C, if necessary. Interpass temperature: <200°C.

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