



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 content. 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

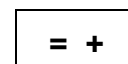
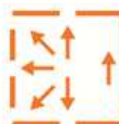
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>380	>560	>35	+20°C >60

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.

FT En-1D6-170116



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr