FCW 16-8-2P

16-8-2 stainless type
All positions rutile flux cored wire

Classification

AWS A5.22 : ~E16-8-2T1-1/-4 ISO 17633-A : T Z 16 8 2 P M21(C1) 1

Description & Applications

Rutile flux cored wire for gas shielded (Ar + CO_2) arc welding for austenitic stainless steel with increased carbon content like 304H, 316H alloys used at service temperature up to 800°C… Good creep and oxidation resistance even under highly restrained conditions. Excellent weldability in position.

Main applications: Petrochemical or incineration industry, nuclear plant.

Base materials:

UNS	Alloy	EN	Material N°
S30409	304H	X6 CrNi18-11	1.4948
S32109	321H	X8 CrNiTi18-10	1.4941
S34709	347H	X8 CrNiNb16-13	1.4961
S31609	316H	X6 CrNiMo17-13	1.4919

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S
Min									
Max					Not specified				
Type	0.06	0.5	1.4	16.5	9.6	1.2	0.1	0.020	0.008

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min					
Max					
Type	460	620	40	+20°C	70

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	130 - 270	22 – 35	12 - 25	ISO 14175: M20/M21 (Ar+CO_2) C1 (CO_2) 18-20 L/min

FT En-CN45-230119