



UP 16-8-2

Classification

AWS A5.9 : ER16-8-2

ISO 14343-A : S 16 8 2

Description & Applications

High carbon solid wire for submerged arc welding of high temperature stainless steels like 304H, 316H, 347H. Mainly used for creep resistant construction or assembly with high service temperature up to 650-700°C.

Main applications: Petrochemical or incineration industry, nuclear plant.

Base materials:

Stainless steels for general uses:

UNS	Alloy	EN 10088	Material N°
S30409	304H	X6CrNi18-11	1.4948
S31609	316H	X6CrNiMo17-13	1.4919
S34709	347H	X6CrNiNb18-10	1.4550

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S
Min		0.30	1.0	14.5	7.5	1.0			
Max	0.10	0.65	2.0	16.5	9.5	2.0	0.5	0.03	0.02
Type	0.04	0.45	1.8	16.0	8.6	1.2	0.15	0.02	0.01

Welding Current & Instructions

	Ø (mm)	Paramètres de Soudage				Flux
		Intensité (A)	Tension (V)	Stick out (mm)	Vitesse (cm/min)	
SAW AC / = +	2.4	200 - 400	25 - 30	18	40 - 60	UP WP380M
	3.2	300 - 500	28 - 32	20	40 - 60	
				22	50 - 60	

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