ER16.8.2 SAW

TOP FEATURES

- High resistance to thermal embrittlement
- Excellent toughness at low temperatures
- Higher creep resistance than 308H grade

CLASSIFICATION

AWS A5.9M	ER16.8.2
EN ISO 14343-A	16 8 2
EN ISO 14343-B	S 16-8-2

CURRENT TYPE

DC+

CHEMICAL COMPOSITION (WEIGHT %), WIRE

	C	Mn	Si	S	P	Cr	Ni	Mo*	Cu	Fe
Min.	0.04	1.0	0.3			14.5	7.5	1.0		1
Max.	0.10	2.0	0.6	0.02	0.03	16.5	9.5	2.0	0.3	6
Typical	0.05	1.7	0.45	0.01	0.01	16.2	8.5	1.3	0.1	3

*Mo 1.0-1.3% on request. Typical ferrite level 1-6 FN.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded		Typical	High Temperature		
			650°C	732°C	816°C
Tensile strength	(MPa)	610	315	241	173
0.2% Proof strength	(MPa)	400	221	178	147
Elongation (%)	4d	35			
	5d	30	31	36	42
Reduction of area (%)		50	67	69	65
Impact ISO-V (J)	-20°C	60			
	-196°C	40			

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.4	SPOOL	25.0	SAER1682-24

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.