

ER16.8.2

SAW

SOLID SAW WIRE FOR 3XXH STAINLESS STEEL

PRODUCT DESCRIPTION

Solid wire for sub-arc welding of 300H stainless steel.

CLASSIFICATIONS

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

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	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 1-6FN.

ALL-WELD MECHANICAL PROPERTIES

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(I) -20°C	60	--	--	--
-196°C	40	--	--	--

TYPICAL OPERATING PARAMETERS

Flux	Current	Diameter (mm)	Voltage
P2007 or SSB flux	350A, DC+	2.4	30V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	25	B415	SAER1682-24
3.2	25	B415	SAER1682-32