

ER16.8.2

MIG (GMAW)

SOLID WIRE MIG FOR 3XXH STAINLESS STEEL

PRODUCT DESCRIPTION

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

CLASSIFICATIONS

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

ALL-WELD MECHANICAL PROPERTIES

As-welded	Typical	High Temperature		
		650°C	732°C	816°C
Tensile strength [MPa]	600	315	241	173
0.2% proof strength [MPa]	410	221	178	147
Elongation [%] 4d	35			
5d	32	31	36	42
Reduction of area [%]	65	67	69	65
Impact ISO-V(I) -20°C	80			

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Ar+2%O ₂ *	DC+	1.2	260A, 26V

* Proprietary Ar and Ar-He gas mixtures with < 3% CO₂ also suitable

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.0	15	S300	MER1682-10
1.2	15	S100	MER1682-12

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr ³	Ni	Mo	Cu	OES (mg/m ³)
40	10	12	7	0.5	< 0.5	4.2

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.