

ER16.8.2

TIG (GTAW)

SOLID WIRE TIG AND SAW FOR 3XXH STAINLESS STEEL

PRODUCT DESCRIPTION

Solid wire for TIG welding and 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
Min.	0.04	1.0	0.3	--	--	14.5	7.5	1.0	--
Max.	0.10	2.0	0.6	0.02	0.03	16.5	9.5	2.0	0.3
Typical	0.06	1.4	0.4	0.01	0.01	15.5	8.5	1.3	0.1

* 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]	620	315	241	173
0.2% proof strength [MPa]	450	221	178	147
Elongation [%] 4d	35	--	--	--
5d	--	31	36	42
Reduction of area [%]	--	67	69	65
Impact ISO-V(I) -196°C	--	--	--	--

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Voltage
Argon	100A	2.4	12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	TER1682-16
2.0	2.5	PE TUBE	TER1682-20
2.4	2.5	PE TUBE	TER1682-24
3.2	2.5	PE TUBE	TER1682-32