EXECUTIVE 16-8-2-16

STAINLESS STEEL

COATED ELECTRODE TECHNICAL DATA SHEET

DESCRIPTION

Executive 16-8-2 provides superior weldability, low spatter and smooth beads with easy slag removal. Provides additional safety in welding highly restrained joints or crack sensitive alloys. Hot ductility properties and relative freedom from weld and crater cracking.

The weld deposit usually has a Ferrite Number no higher than 5 FN. The deposit also has good, hot ductility properties which offer relative freedom from weld or crater cracking even under high-restraint conditions. These electrodes depend on a very carefully balanced chemical composition to develop their fullest properties. Corrosion tests indicate that Type 16-8-2 weld metal may have less corrosion resistance than Type 316 base metal depending on the corrosive media. Where the weldment is exposed to severely corrosive agents, the surface layers should be deposited with a more corrosion-resistant weld metal.

APPLICATIONS & FEATURES

Suitable for welding types 16-8-2, 316 and 347 stainless steels in high temperature piping systems. Used for welding cat crackers, furnace parts and petrochemical/power generation industry components.

Executive 16-8-2 is usable in either the as-welded or solution-treated condition.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.061	0.53	1.03	0.026	0.003	15.60	8.11	1.25	0.03

Tensile Strength: 88,000 PSI min
Yield Strength: 56,000 PSI min
Elongation: 42%

TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
SMAW	3/32"	12"	40-70
AC/DC	1/8"	14"	60-100
	5/32"	14"	90-140
	3/16"	14"	120-185

STANDARD PACKAGING & HANDLING

SMAW 40-lb master box
10-lb plastic tube

CLASSIFICATION

AWS/SFA 5.4, Class **E16-8-2-16**