# STAINLESS STEEL ELECTRODES

## **PRODUCT DATA SHEET**

### **AFROX E16.8.2**

AFROX E16.8.2. is a rutile-Aluminosilicate coated low carbon electrode. The consumable has a controlled composition optimised for performance in structural service at temperatures up to 800°C. It is essentially a dilute hybrid between 308H and 316H. Rather than matching any single parent metal, it has applications for welding all the 3XXH series of stainless steels with up to 0.04-0.10% Carbon.

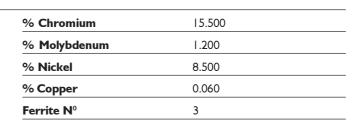
#### CLASSIFICATION

AWS

A5.4 E16.8.2-15

#### CHEMICAL ANALYSIS (TYPICAL)

0.050	
1.800	
0.300	
0.010	
0.020	
	1.800 0.300 0.010



Applications include catalytic crackers, cyclones, transfer lines,

furnace parts, thick wall steam piping, superheater headers, gas

and steam turbine components in the petrochemical, chemical

process plants and power generation industries.

#### TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL)

	As welded	650°C	732°C	816°C
2% Proof Stress	>410 MPa	216 MPa	187 MPa	132 MPa
Tensile Strength	>620 MPa	294 MPa	230 MPa	165 MPa
Elongation 5d %	40%	27%	36%	57%
Charpy V-Notch at -100°C	>50J	-	-	-

#### **PACKING DATA**

Diameter (mm)	Electrode Length (mm)	Amps	ltem Number	Pack Mass (Kg)
3.2	350	75 - 120	078-513	3 x 4.5
4.0	350	100 - 155	078-514	3 x 4.5

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre,

tel: 0860 020202 or e-mail: customer.service@afrox.boc.com Website: www.afrox.com

