

DESCRIPTION

Executive 16-8-2 wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool, Executive wire provides welders with the highest quality stainless bare wire.

Executive 16-8-2 offers great mechanical properties in structural environments ranging from -320°F (-196°C) to 1472°F (800°C) resisting both cryogenic stresses at the low end and hot cracking in the high temperature spectrum. Additionally, it provides a fully austenitic weld deposit.

Primarily utilized for welding stainless steel types 16-8-2, 316 and 347 for high pressure, high temperature piping systems.

APPLICATIONS & FEATURES

Executive 16-8-2 is used in cat crackers, furnace parts, petrochemical, chemical processing, power generation, cryogenic applications, general manufacturing and fabrication.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	Nb	B
0.049	15.26	8.13	1.24	1.32	0.44	0.017	0.001	0.02	0.052	<0.01	0.0009
Tensile Strength:		87,800 PSI min		Elongation:		38%		Ti		0.03	
Yield Strength:		n/a		WRC-92:		1.5 FN		V		As	
										0.001	

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short - Spray	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar
	.045"	22-23	180-210		
	.062"	23-24	200-220		
	.035"	23-25	190-260		
	.045"	25-28	250-330		
	.062"	28-31	310-350		
GTAW	.093" & .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.093"	29-32	300-350		Record IND 24 or Record IN
	.125"	29-32	400-550		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER16-8-2** Certified by the Canadian Welding Bureau (CWB) to AWS A5.9

