

DESCRIPTION

Executive 16-8-2P is a gas -shielded, flux cored wire designed to weld in all positions. It has a nominal composition of 15.5% Cr, 8.5% Ni and 1.5% Mo.

This wire is designed to run on 100% CO₂ or M21 Ar / CO₂ mixture. Shielding gas mixtures with more than 75-80% argon are not Recommended.

APPLICATIONS & FEATURES

Executive 16-8-2P may be used to weld 16-8-2, 316 and 347 grade stainless steels used in high temperature piping systems. It has good hot ductility properties and is well suited for welding cat crackers, furnace parts, and components used in the petrochemical, chemical processing and power generation industries.

Executive 16-8-2P provides superb performance characteristics in all positions, using either CO₂ or M21 shielding gas. Flat, well washed beads can be achieved with minimal weaving. Spatter is very low and slag peeling is excellent, minimizing cleanup.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	
0.02	15.50	8.50	1.50	1.50	0.70	0.02	<0.01	0.2	
Tensile Strength:		86,000 psi		Elongation:		38%		Ferrite Range: 1-5 (WRC-1992)	
Yield Strength:		56,000 psi							

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045"	24	130	250	100% CO ₂
.045"	26	160	300	100% CO ₂
.045"	28	200	425	100% CO ₂
.062"	25	170	150	100% CO ₂
.062"	27	215	195	100% CO ₂
.062"	28	250	240	100% CO ₂

*Shielding gas flow rate 35 to 50 CFH. For M21 gas mixture, reduce by 2 volts.

STANDARD PACKAGING

FCAW 25-LB or 33-lb plastic spool

CLASSIFICATION

There is currently no AWS classification for 16-8-2 FCAW wire under AWS A5.22/ASME SFA-5.22. However, this wire can be certified as a "G" class as follows: AWS A5.22/ASME SFA-5.22, Class **EGT-1/4**.