

MIDALLOY MASTERCOR E16-8-2 A/P Flux-Cored Wire

CLASSIFICATION

- Non-AWS; chemistry meets AWS 5.4 Class E16-8-2 & AWS 5.9 Class ER16-8-2
- In accordance with UNS Number S16880
- Manufactured in accordance to the same processes as used for other products defined in AWS 5.22

DESCRIPTION

- MIDALLOY MASTERCOR E16-8-2 is an all-position stainless steel flux-cored welding wire that utilizes external shielding gas.
- Ferrite content is usually < 5 FN.

APPLICATIONS

- MIDALLOY MASTERCOR E16-8-2 is used for joining similar alloys such as 16-8-2, 316, 316H, 304H, and 347. It is used extensively for joining type 3XX and type 3XXH materials..
- Provides good ductility at elevated temperatures.
- Midalloy Mastercor E16-8-2 weld metal can be used in the as welded or solution annealed condition.
- Used in the construction of power plant, oil & gas refineries, and chemical processing plants.

TYPICAL CHEMISTRY

C	Si	Cr	Mn	P	S	Ni	Mo
.02	.70	15.5	1.5	.015	.010	8.5	1.5

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	86,500 PSI
YIELD STRENGTH	55,500 PSI
ELONGATION IN 2"	39%

RECOMMENDED WELDING PARAMETERS (100% CO₂)*

PROCESS	DIAMETER	VOLTAGE	WIRE FEED	AMPERAGE	SHIELDING GAS
FCAW	.035"	25-26	400 - 600	130 - 160	100% CO ₂ or 75% Ar / 25% CO ₂
	.045"	26-28	300 - 450	150 - 210	
	1/16"	28-29	150 - 240	170 - 250	

*REDUCE VOLTAGE BY 2 VOLTS WHEN USING 75% Ar / 25% CO₂

PACKAGING

- 33 Lb. Spools

2/5/21

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