

MIDALLOY ER16-8-2 BARE WIRE

CLASSIFICATION

- AWS 5.9 Class ER16-8-2 / ASME SFA 5.9 Class ER16-8-2
- UNS S16880 A#8 F#6

DESCRIPTION

- MIDALLOY ER16-8-2 stainless steel wire is used for GMAW, GTAW, and SAW welding.
- Ferrite content is < 5FN.

APPLICATIONS

- MIDALLOY ER16-8-2 is used for joining similar alloys such as 16-8-2, 316, and 347. It is used extensively for joining type 3XX and type 3XXH materials.
- MIDALLOY ER16-8-2 can be used for GMAW, GTAW, and SAW welding. It provides good ductility at elevated temperatures.
- MIDALLOY ER16-8-2 weld metal can be used in the as welded or solution annealed condition.

TYPICAL CHEMISTRY

C	Si	Cr	Mn	P	Cu	S	Ni	Mo	N
.05	.40	15.7	1.3	.015	.05	.010	8.1	1.5	0.045

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	89,500 PSI
YIELD STRENGTH	47,500 PSI
ELONGATION IN 2"	39%

RECOMMENDED WELDING PARAMETERS

PROCESS	DIAMETER	VOLTAGE	AMPERAGE	GAS / FLUX
TIG (GTAW)	1/16"	14-18	90-130	100% Ar
	3/32"	15-20	120-175	100% Ar
	1/8"	15-20	150-220	100% Ar
MIG (GMAW)	.035" SHORT ARC	16-26	70-160	90%He/7.5%Ar/2.5%CO ₂ or 69%Ar/30%He/1%O ₂
	.035" SPRAY ARC	26-31	150-230	92%Ar/8%CO ₂ or
	.045" SPRAY ARC	28-32	180-280	98%Ar/2%O ₂
SUB-ARC (SAW)	3/32"	28-30	275-350	RECORD IN® or
	1/8"	29-32	350-450	RECORD IND 24®

PACKAGING

- TIG: 10 Lb. Tube / 60 Lb. Carton
- MIG: 30 Lb. Spool
- SUB-ARC: 60 Lb. Coil

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