

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.



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.

CLASSIFICATION

AWS A5.4 E16.8.2-15

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.050	% Chromium	15.500
% Manganese	1.800	% Molybdenum	1.200
% Silicon	0.300	% Nickel	8.500
% Sulphur	0.010	% Copper	0.060
% Phosphorous	0.020	Ferrite N°	3

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	Item 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

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