



AFROX SUBARC 16.8.2

AFROX SUBARC 16.8.2 is a solid wire for welding 300H series stainless steel. 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 A5.9 ERI 6.8.2

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.060	% Chromium	15.500
% Manganese	1.400	% Molybdenum	1.300
% Silicon	0.400	% Nickel	8.500
% Sulphur	0.010	% Copper	0.100
% Phosphorous	0.020	Ferrite N^o	1-6

TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL)

	As welded
2% Proof Stress	360 MPa
Tensile Strength	630 MPa
Elongation 4d %	29%
Charpy V-Notch at -196°C	30J

PACKING DATA

DC+

Diameter (mm)	Amps	Volts	Item Number	Pack Mass (Kg)
2.4	350	30	078-520	25

Recommended Flux Afrox MK-SS or Metrode SSB

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