



Unibraze 16.8.2

CLASSIFICATIONS: AWS A5.9/ASME SFA 5.9 Class ER16.8.2 UNS S16880

DESCRIPTION: Unibraze 16.8.2 solid stainless steel wire for GTAW 300H stainless steels. The consumable has a controlled composition optimized for performance in structural service at temperatures up to 800°C. Is essentially a dilute hybrid between 308H and 316H. Rather than matching any single parent metal, it has application for welding all 3XXH series of stainless steels with up to .04-.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 in power generation industries.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	FN (WRC)
.06	15.5	8.5	1.3	1.4	1.4	.02	.01	.1	1-6

TYPICAL MECHANICAL PROPERTIES:

As Welded TIG	
Tensile Strength	>90,000 psi
.2% Proof Stress	>60,000 psi
Elongation 4d	35%

TYPICAL WELDING PARAMETERS:

	Shielding Gas	Diameter	Voltage	Amperage
TIG	100% Ar	3/32" (2.4mm)	12	100

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.