

Standards

TS EN ISO 3581-A	: E Z 16 8 2 B 22
EN ISO 3581-A	: E Z 16 8 2 B 22
AWS A5.4	: E 16 8 2-15

**Chemical Composition of
Weld Metal % (Typical)**

C	Cr	Ni	Mo
0.05	16.0	8.5	1.3

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 410	min. 550	min. 47 J	min. 35

Features and Applications

- Basic coated electrode is used primarily for welding stainless steel, such as types 16-8-2, 316, and 347, for high pressure, high-temperature piping systems
- A controlled chemical composition and ferrite number (<5 FN) of weld metal gives good creep, oxidation and general corrosion resistance

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101618	3.20 x 350	1/8 x 14"	100 - 130	3200

Approvals: CE, SEPRO