55 YEARS Since 1968

Estd. 1966
DNH sécheron
Complete Welding Support

BATOX-16/8/2

CODIFICATION: AWS : SFA 5.4 E16-8-2-15

CHARACTERISTICS AND APPLICATIONS:

Batox-16/8/2 is a basic coated, stainless steel electrode depositing 15.5Cr – 8.5Ni – 1.3Mo stainless steel weld metal. Electrodes provide excellent operating characteristics with easy slag detachability. The lean composition of weld metal minimize the in-service formation of inter-metallic compound, excellent hot ductility properties which offer freedom from weld or crater cracking even under high-restraint conditions. This lean version weld metal is ideally suited for welding stainless steels, such as types 16-8-2, 304H, 316H and 347H for high pressure, high temperature piping systems, and catalytic cracker structures.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	S	P	Cr	Ni	Mo
Percent	0.05	1.20	0.52	0.015	0.020	15.5	8.5	1.3

FERRITE (AS WELDED): 5.0 Max. As Per WRC 1992

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 4d)%
600	38.0

CURRENT AND PACKING DATA: DC(+)

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	150-180	110-140	80-100	60-80
Quantity (kgs/Carton)	2.5	2.5	2.5	2.5

PRECAUTIONS:

1. Re-dry the electrodes at 250-300°C for one hour, as per our standard recommended practice.
2. Use short arc, stringer bead, smallest size of electrode and minimum current to ensure minimum heat input.