



# CEWELD 16.8.2 Tig

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                   |          |        |                         |      |     |          |      |
|------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|----------|--------|-------------------------|------|-----|----------|------|
| TYPE                                           | A specially designed hybrid alloy between 308H and 316H for high temperature applications.                                                                                                                                                                                                                                                                                                                                                                                                                             |                   |          |        |                         |      |     |          |      |
| ANWENDUNGEN                                    | Used mainly in power generation and chemical process industries on applications such as, steam turbines, catalytic crackers, transfer piping and furnace accessories.                                                                                                                                                                                                                                                                                                                                                  |                   |          |        |                         |      |     |          |      |
| EIGENSCHAFTEN                                  | A specially designed composition where Molybdenum % is reduced to form a hybrid alloy between 308H and 316H, operates in temperatures up to 800 °C. CEWELD® 16.8.2 Tig gives a very high resistance to thermal embrittlement. Creep ductility is enhanced at temperatures above 650 °C.                                                                                                                                                                                                                                |                   |          |        |                         |      |     |          |      |
| KLASSIFIKATION                                 | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.9: ER16-8-2   |          |        |                         |      |     |          |      |
|                                                | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 14343-A: W 16 8 2 |          |        |                         |      |     |          |      |
|                                                | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 4                 |          |        |                         |      |     |          |      |
|                                                | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 5                 |          |        |                         |      |     |          |      |
| GEEIGNET FÜR                                   | 1.4948, 1.4941, 1.4961, 1.4919,<br>X6CrNi18-10, X8CrNiTi18-10, X8CrNiNb16-13, X6CrNiMoB17-12-2,<br>304H, 321H , 347H, 316H,<br>UNS 30409, S32109,S34709, S31609, 304S51, 321S51, 347S51, 316S51, 316S53                                                                                                                                                                                                                                                                                                                |                   |          |        |                         |      |     |          |      |
| ZULASSUNGEN                                    | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                   |          |        |                         |      |     |          |      |
| SCHWEISSPOSITIONEN                             | <div>     </div> |                   |          |        |                         |      |     |          |      |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                | Mn       | P      | S                       | Cr   | Ni  | Mo       | Cu   |
|                                                | 0.05                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.4               | 1.3      | 0.01   | 0.003                   | 15.3 | 8.4 | 1.2      | 0.02 |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | RP0,2 (MPa)       | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V |      |     | Hardness |      |
|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                   |          |        | -196°C                  |      |     |          |      |
|                                                | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 420               | 850      | >35    | 90                      |      |     | HRc      |      |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                   |          |        |                         |      |     |          |      |
| GAS ACC. EN ISO 14175                          | I1, I3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                   |          |        |                         |      |     |          |      |



# CEWELD 16.8.2 Tig

16.8.2 TIG 2,4 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663413253 |