

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY 16-8-2

● Applicable Specification

JIS Z 3221 ES16-8-2-16
AWS A5.4 E16-8-2-16

● Identification Color

End Face: White
Side Face: Light Sky Blue

● Applications and Characteristics

TASETO RNY16-8-2 has a full austenitic structure. Because of less susceptibility to hot cracking and sigma embrittlement, it is used for welding of equipment operated in elevated temperatures.

RNY16-8-2 is a lime-titania type electrode suitable for positional welding.

● Notes on Usage

* Dry the electrode at 150°C to 200°C for 60 minutes before use.

* Avoid excessively high current or wide weaving to prevent hot cracking..

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.089	0.42	1.54	0.009	0.008	8.56	15.21	1.85	0.10

● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 20°C (J)
Typical	645	37.0	80*

※PWHT: 750°C×20h, AC

● Typical Creep Rupture Strength of All Weld Metal

650°C×1,000h : 208MPa

● Other Properties of All Weld Metal

* Typical Ferrite Content : 0% (Schaeffler's Diagram)

* 10% Sulfuric Acid·3% Hydrofluoric Acid Test : max. 15 g/m²·h

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—