

MIDALLOY CHROMAX E316-16/E316H-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E316-16 and E316H-16 / ASME SFA 5.4 Class E316-16 and E316H-16
- UNS W31610 ASME Sec. IX, F#4, A#8
- EN3581-A E19122R

DESCRIPTION

- MIDALLOY CHROMAX E316-16/E316H-16 is an AC-DC titania coated electrode

APPLICATION

- For welding or repairing alloy 316 or 316H with base metal with nominal chemistries of 18.5Cr, 12.5Ni, and 2.5Mo.
- Good creep resistance at high temperature due to the Mo content.
- The carbon content in the range of .04 to .08% provides higher tensile and creep strengths at elevated temperatures.
- Can be used for overlay of carbon steel and build-up for stainless steels.
- For welding or repair welding CF-8M cast stainless steels.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Bi	N
.05	19.5	13.3	2.5	1.2	.50	.020	.010	.10	.003 max	.06

FERRITE CONTENT 4-9 WRC 1992

TYPICAL MECHANICAL PROPERTIES (as welded all weld metal)

TENSILE STRENGTH	85,250 PSI
YIELD STRENGTH	66,000 PSI
ELONGATION IN 2"	38%

RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32"	70-85	65-75
1/8"	85-110	80-90
5/32"	110-140	100-120
3/16"	120-160	110-130

STANDARD PACKAGING

3/32" 8 lb. can / 48 lb. carton
 1/8", 5/32", and 3/16" 10 lb. can / 60 lb. carton

6/30/16

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