MIDALLOY CHROMAX E320LR-16 COATED ELECTRODE

CLASSIFICATION
- AWS/SFA 5.4 Class E320LR-16/ASME SFA 5.4 Class E320LR-16, UNS W88022
- A #9   F #5

DESCRIPTION
- Midalloy Chromax E320LR-16 coated electrode is an all-position coated electrode used for joining alloys listed under the UNS number N08020 to themselves.
- Chromax E320LR-16 can also be used for dissimilar welds between most Nickel-based alloys such as UNS number N08020, stainless steel, and low alloy or carbon steels, without need to preheat. (Stress-relief may follow if called for.)
- LR stands for low residual values for impurities and lower S, P, Si, C levels improves the weldability.
- Chromax E320LR-16 is a 100% austenitic alloy that contains no ferrite.

APPLICATION
- Because of the excellent corrosion resistance, Chromax E320LR-16 coated electrodes are used in petrochemical and power generation plants for long-term service at elevated temperatures.

TYPICAL CHEMISTRY

C	Mn	Mo	P	S	Si	Cu	Ni	Cr	Cb+Ta	Fe
.012	1.64	2.7	.010	.003	.18	3.5	34.5	19.8	8 X C, 0.4 max	Bal

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	75,000 PSI Minimum
Yield Strength	57,000 PSI
Elongation	34%

RECOMMENDED WELDING PARAMETERS

Diameter	**3/32"**	**1/8"**	**5/32"**	**3/16"**
Process	SMAW	SMAW	SMAW	SMAW
Voltage	24-28	26-30	28-32	28-32
Amperage Flat	70-85	65-100	110-140	120-160
Amperage Vertical/Overhead	55-75	65-90	100-120	110-130

Low heat input and concave beads are required to prevent hot cracking.

STANDARD PACKAGING
- 3/32"   8 lb. Can / 48 lb. Carton
- 1/8", 5/32" and 3/16"   10 lb. Can / 60 lb. Carton

5/1/20

Midalloy