

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

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.

Office and Corporate Warehouse
 630 Axminister Drive
 St. Louis, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

