

MIDALLOY CHROMAX E330-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E330-16 / ASME SFA 5.4 Class E330-16

DESCRIPTION

- MIDALLOY CHROMAX E330-16 is AC-DC Titania Coated Electrode (UNS W88331)

APPLICATION

- For welding or repairing high alloy head and corrosion resistant castings of the same general composition, which are designated HT by the alloy castings institute.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
.18-.25	16.0	35.4	0.55	1.80	.65	.015	.005	.08

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	84,500 PSI
YIELD STRENGTH	57,000 PSI
ELONGATION IN 2"	26%

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", 3/16" - 10 lb. Can., 60 lb. Carton

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