

MIDALLOY CHROMAX E385-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E385-16 / ASME SFA 5.4 Class E385-16
- UNS# W88904
- ASME Sec. IX, F# 6, A# None

DESCRIPTION

- MIDALLOY CHROMAX E385-16 is an AC-DC titania coated electrode.

APPLICATION

- MIDALLOY CHROMAX E385-16 is primarily used for joining similar compositions such as type 904L (UNS N08904) in wrought and cast forms, for use in the handling of sulfuric acid and chloride-containing media.
- This product can also be used to join type 317L material where additional corrosion resistance is required.
- The product is vacuum melted to reduce levels of carbon, phosphorus, and sulfur to reduce weld metal cracking and fissuring.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe
.015	20.5	25.0	4.80	1.85	.48	.015	.010	1.50	Bal

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	78,000 PSI
YIELD STRENGTH	65,500 PSI
ELONGATION IN 2"	35%

RECOMMENDED WELDING PARAMETERS

PROCESS	DIAMETER	VOLTAGE	AMPERAGE (DCRP)
SMAW	3/32"	18-24	65-85
	1/8"	18-24	80-110
	5/32"	18-24	100-140
	3/16"	18-26	110-165

STANDARD PACKAGING

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

3/2/17

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