

MIDALLOY CHROMAX E209-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E209-16 / ASME SFA 5.4 Class E209-16, UNS W32210
- AWS D1.6 FILLER METAL GROUP E

DESCRIPTION

- MIDALLOY CHROMAX E209-16 is AC-DC Titania Coated Electrode
- Smooth arc and easy slag removal
- All-Position operation

APPLICATION

- Midalloy E209-16 is used to join Nitrogen-strengthened stainless steels, like UNS S24100
- Can be used to weld ASTM A276 Type XM-28 and Type XM-19, ASTM A955 Type XM-28, AISI Type 208 (UNS S20910)
- Can be used to weld Nitronic 30, 32, 33, 40, & 50 to themselves, and Nitronic 50 to some stainless steels
- Overlaying mild-steel for corrosion applications and added wear and galling resistance
- Dissimilar metal combinations of carbon steels to nitrogen-strengthened stainless steels.
- Approved for welding high strength re-bar (reference AWS D 1.6 base metal groups D and E)

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	V	N	Cu
0.04	22.5	10.5	1.8	4.5	0.75	0.015	0.005	0.10	0.20	0.4

TYPICAL MECHANICAL PROPERTIES ALL WELD METAL

TENSILE STRENGTH	100,000 PSI MIN.
ELONGATION IN 2"	15% MIN.

WELDING PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE	
		FLAT	VERTICAL & OVERHEAD
3/32"	22-28	70-85	65-75
1/8"	21-28	85-110	80-90
5/32"	22-28	110-140	100-120
3/16"	22-30	120-160	110-130

STANDARD PACKAGING

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

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