

Stainless Steel Electrodes

Alloy: WW420-16

Conforms to Certification: AWS A5.4

Class: E420-16

ASME A5.4

Alloy: E420-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.27 max Si = 0.38 max
Cr = 12.70 max P = 0.021 max
Mn = 0.40 max S = 0.024 max

Deposited Chemical Composition % (Typical)

C = 0.11 Cr = 10.90 Si = 0.28
Mn = 0.22 P = 0.017 S = 0.014

Deposited All Weld Metal Properties %
(Typical) As-Welded

Not Applicable

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

Diameter	Voltage	Amperage	
		Flat	Vertical & Overhead
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130

Application

E420-16 is structured for surface applications on carbon steels for good resistance to abrasion. Preheat and interpass temperature of more than 400°F is recommended during welding. Use slow cooling.