

STAINLESS STEEL ELECTRODES E420-16

Classification: E420-16

AWS A5.4 / ASME A5.4

Source: WELDWIRE COMPANY, INC. Technical Information

Weld Process: Shielded Manual Metal Arc

Alloy: WW420-16 / E420-16

Conforms to Certification: AWS A5.4 / ASME A5.4

Description, Characteristics & Applications:

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.

AWS Chemical Composition Requirements

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

Deposited Chemical Composition (%) (Typical)

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

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

Result
Not Applicable

Deposited Charpy-V-Notch Impact Properties (%)

Result
Not Applicable

Recommended Welding Parameters

Diameter	Voltage	Amperage Flat	Amperage 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

If additional information is needed, contact Weldwire Company, Inc. 800-523-1266.

The above information is to be used as a guideline and is based on the source Technical Information sheet.

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