

Stainless Steel Electrodes

Alloy: WW316H-16 Class: E316H-16

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

Alloy: E316H-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.04 – 0.08	Si = 1.0 max
Cr = 17.0 – 20.0	P = 0.04 max
Ni = 11.0 – 14.0	S = 0.03 max
Mo = 2.0 – 3.0	Cu = 0.75 max
Mn = 0.5 – 2.5	

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

Yield Strength	88,000psi
Tensile Strength	58,000psi
Elongation	37%

Deposited Chemical Composition % (Typical)

C = 0.06	Si = 0.60
Cr = 19.00	P = 0.023
Ni = 12.80	S = 0.022
Mn = 1.80	Mo = 2.50

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

<u>Diameter</u>	<u>Voltage</u>	<u>Amperage Flat Position</u>	<u>Amperage Vertical & Overhead</u>
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

E316H-16 can be used in all applications that E316-16 is used in. In addition it can be used to weld type E316H where improved creep strength is required.

