WELDWIRE COMPANY, INC. **Technical Information**

Stainless Steel Electrodes

Alloy: WW330-16 Class: E330-16

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

Alloy: E330-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.18 – 0.25	Si = 1.0 max
Cr = 14.0 – 17.0	P = 0.04 max
Ni = 33.0 – 37.0	S = 0.03 max
Mo = 0.75 max	Cu = 0.75 max
Mn = 1.0 – 2.5	

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

Yield Strength	85,000psi
Tensile Strength	56,500psi
Elongation	27%

Deposited Chemical Composition % (Typical)

C = 0.21	Si = 0.50
Cr = 15.40	P = 0.021
Ni = 34.10	S = 0.021
Mn = 1.95	Mo = 0.52

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

Diameter	Voltage	Amperage Flat Position	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

Application

E330-16 is used to weld matching composition of wrought and cast alloys. It has a good resistance to oxidation at elevated temperatures.

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