

E 330-16

Lime-titania type electrode for producing weld deposit with perfect structure of Austenite

CLASSIFICATION : AWS/SFA-5.4: E 330-16

APPROVAL :

CHARACTERISTICS : E 330-16 lime-titanium type electrode depositing 0.2C-15.5Cr-35 Ni. These electrodes are commonly used where heat and scale-resisting properties above 980°C or require. However high sulfur environments may adversely affect performance at elevated temperature.

APPLICATION :

- 1) As the weld metal contains high Ni, it has good acid resistibility and heat resistibility.
- 2) It can be used for welding of cast Iron and wrought alloys products where heat resistibility is required as in furnace equipment.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni
0.18-0.25	1.00-2.50	1.00 Max	0.030 Max	0.040 Max	14.00-17.00	33.00-37.00

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)
520 min.	25 Min.

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC-/AC) Amps	kg/packet.	kg/case.
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	75-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	150-180	2	20

Customer packing on request.