DURAMAX 320-16 - DM320-16 FLUX COATED STAINLESS STEEL ELECTRODE

Classification: AWS A5.4 / ASME SFA 5.4

Typical Characteristics & Application

DURAMAX E320-16 has a nominal composition (wt %) of this weld metal is 20 Cr, 34 Ni, 2.5 Mo, 3.5 Cu with Nb added to improve resistance to intergranular corrosion. These electrodes are primarily used to weld base metals of similar composition for applications where resistance to severe corrosion is required for wide range of chemicals including sulfuric and sulfurous acids and their salts. DM320-16 can be used to weld both castings and wrought alloys of similar compositions without postweld heat treatment.

All Weld Chemical Composition (%)

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.07 max	19.0 - 21.0	32.0 - 36.0	2.0 - 3.0	0.50 - 2.50	0.60 max	0.04 max	0.03 max	3.0 - 4.0

Nb + Ta = 8 x C min / 1.00 max

Typical Mechanical Properties

Tensile Strength	Elongation	Ferrite WRC
520 N/mm2	30%	9

Sizes available and Typical Weld Parameters

DIAMETER	3/32"	1/8"	5/32"	3/16"
FLAT	70 - 85	85 - 110	110 - 140	120 - 160
V & OH	65 - 75	80 - 90	100 - 120	110 - 130

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please visit our website www.duramaxwelding.com