DURAMAX 320LR-16 - DM320LR-16 FLUX COATED STAINLESS STEEL ELECTRODE

Classification: AWS A5.4 / ASME SFA 5.4

Typical Characteristics & Application

DURAMAX 320LR flux-cored electrodes are a modified version of DM320 electrodes, where the "residuals" – carbon, silicon, phosphorus and sulfur are specified at lower maximum levels. Niobium (Columbium) and manganese are also maintained within tighter parameters. These strict controls eliminate hot cracking and microfissuring frequently encountered in austenitic stainless steel. DM320LR-16 has excellent corrosion resistance against sulfuric acid, phosphoric acid and other chemicals. It is especially suited for pipe welding.

Re-Dry the electrode at 350°C for 60 minutes prior to use.

All Weld Chemical Composition (%)

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.03 max	19.0 - 21.0	32.0 - 26.0	2.0 - 3.0	1.50 - 2.50	0.30 max	0.02 max	0.015 max	3.0 - 4.0

Nb + Ta = 8 x C min / .040 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

DURAMAX Brand **103 Queens Drive** **King of Prussia, PA 19406**
Phone: (484) 808-4200 **Toll free: (800) 692-5930** **Fax: (610) 265-7806**

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