



# PRODUCT

## DATA SHEET

### Stainless Steel Electrode

Weld Process: Shielded Manual Metal Arc

Alloy: 420 Class: E420-16

Conforms to Certification: AWS A5.4 / ASME SFA 5.4

Alloy: DM420-16

#### AWS Chemical Composition Requirements

C = 0.27 max      Si = 0.38 max  
Cr = 12.70 max    P = 0.021 max  
Mn = 0.40 max    S = 0.024 max

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

Not Applicable

#### Deposited Charpy-V-Notch Impact Properties %

Not Applicable

#### Deposited Chemical Composition % (Typical)

C = 0.11      Cr = 10.90      Si = 0.28  
Mn = 0.22    P = 0.017      S = 0.014

#### Recommended Welding Parameters

<u>Diameter</u>	<u>Voltage</u>	<u>Amperage Flat Position</u>	<u>Amperage Vertical &amp; 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

E420-16 is structured for surface applications on carbon steels for good resistance to abrasion. Preheat and interpass temperature of more than 400°F is recommended during welding. Use slow cooling.

For additional information please visit our website at [Duramax-weld.com](http://Duramax-weld.com) or email [info@duramax-weld.com](mailto:info@duramax-weld.com)



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