

ARCTEC[®] STAINLESS STEEL ELECTRODES



a quality welding alloy

ARCTEC[®] E385-16 AWS A5.4 Class E385-16

DESCRIPTION AND APPLICATION:

Arctec[®] E385-16 is primarily used for welding Type 904L materials or alloys of similar composition and is utilized in severely corrosive environments such as handling of sulfuric acid and many chloride-containing media. E385-16 can also be used for joining Type 904L base metal to other grades of stainless. In order to reduce the propensity for fissuring and hot cracking, the low melting constituents such as carbon, silicon and phosphorous are controlled to lower levels in this alloy.

Typical Mechanical Properties: Tensile Strength: 86,500 psi (600 MPa) Elongation 36% - 2"

Typical Deposit Analysis:

	C	Cr	Ni	Mn	Si	Cu	Mo	S	P	N
%	.019	20.5	25.1	2.05	.35	1.6	4.6	.015	.014	.04

RECOMMENDED OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Diameter	2.50 mm 3/32"	3.25 mm 1/8"	4.0 mm 5/32"	5.0 mm 3/16"
Amperage	60-80	80-100	110-140	140-180

ARCTEC[®] E2209-16 AWS A5.4 Class E2209-16

DESCRIPTION AND APPLICATION:

Arctec[®] E2209-16 is primarily used for welding duplex stainless steels which contain approximately 22% chromium. Weld metal deposited by these electrodes has a duplex microstructure consisting of an austenite-ferrite matrix. The weld metal combines increased tensile strength with improved resistance to pitting corrosive attack and to stress corrosion cracking.

Typical Mechanical Properties: Tensile Strength: 100,000 psi (690 MPa) Elongation 20% - 2"

Typical Deposit Analysis:

	C	Cr	Ni	Mn	Si	Mo	S	P	N
%	0.04	22.4	9.0	1.65	.52	3.3	.012	.016	.16

RECOMMENDED OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Diameter	2.50 mm 3/32"	3.25 mm 1/8"	4.0 mm 5/32"	5.0 mm 3/16"
Amperage	60-80	80-100	110-140	140-180

CALGARY FAX:(403)-250-7682	EDMONTON: (780)-484-4896	VANCOUVER: (604)-596-2940	WINNIPEG: (204)-663-7955
PHONE:(403)-250-9355	(780)-484-3304	(604)-596-6207	(204)-663-9182

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Subject to change without notice

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