



Unibrazed 330-16

Specifications: AWS A5.4/ASME SFA 5.4 Class E330-16 UNS W88331

Description: Unibrazed 330-16 is a fully austenitic stainless steel electrode used to weld matching composition wrought and cast alloys. It offers good heat and scale resistance to 1800°F (980°C). High sulfur environments adversely affect the high temperature performance, therefore, heat input must be kept to a minimum to prevent micro-fissuring.

Typical Chemistry

<u>C</u>	<u>Cr</u>	<u>Ni</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>	<u>Cu</u>	<u>Mo</u>
.18 - .25	14.0 – 17.0	33.0 - 37.0	1.0 – 2.5	.90 max	.04 max	.03 max	.75 max	.75 max

Typical All Weld Metal Properties

Tensile Strength	56,500 psi
Yield Strength	85,000 psi
Elongation	27%

Recommended Parameters (AC or DC+)

Diameter	3/32"	1/8"	5/32"	3/16"
F/H-fillet	70-85 amps	85-110 amps	110-140 amps	120-160 amps
V-up/OH	65-75 amps	80-90 amps	100-120 amps	110-130 amps
Voltage	24-28	26-30	28-32	28-32