

EXCALIBUR® 320LR-16

Stainless • AWS E320LR-16



KEY FEATURES

- Good corrosion resistance in acidic environments
- Low heat input welding procedures should be used to prevent solidification cracking

CONFORMANCES

AWS A5.4/A5.4M: 2012

E320LR-16

ASME SFA A5.4:

E320LR-16

TYPICAL APPLICATIONS

- Process Piping
- Heat Exchangers
- Welding Alloy 20 and similar materials
- Chemical Processing Plants

WELDING POSITIONS

All, except vertical down

DIAMETERS / PACKAGING

Diameter		Length		8 lb (3.6 kg) Easy Open Can	10 lb (4.5 kg) Easy Open Can
in	(mm)	in	(mm)	24 lb (10.9 kg) Master Carton	30 lb (13.6 kg) Master Carton
3/32	(2.4)	12	(305)	ED034999	
1/8	(3.2)	14	(355)		ED035000
5/32	(4.0)	14	(355)		ED035001
3/16	(4.8)	14	(355)		ED035002

DEPOSIT COMPOSITION(1) - As Required per AWS A5.4/A5.4M: 2012

	%C	%Cr	%Ni	%Mo	%Nb+Ta	%Mn
Requirements						
AWS E320LR-16	0.03 max	19.0 - 21.0	32.0 -36.0	2.0 - 3.0	0.4 max	1.50 - 2.50
Typical Results(2)	0.02	19.9	33.8	2.3	0.1	1.70
	%Si	%P	%S	%Cu	FN	
Requirements						
AWS E320LR-16	0.30 max	0.020 max	0.015 max	3.0 - 4.0	Not Required	
Typical Results(2)	0.16	0.016	0.006	3.2	-	

TYPICAL OPERATING PROCEDURES

	Current (Amps)			
Polarity(5)	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
AWS E310-16				
DC+/AC	40 - 80	75-110	95 - 150	130 - 200

