

EXCALIBUR® 330-16

Stainless • AWS E330-16



KEY FEATURES

- Offers good heat and scale resistance to 1800°F (980°C)
- Low heat input welding procedures should be used to prevent solidification cracking
- High sulfur environments adversely affect the high temperature performance

CONFORMANCES

AWS A5.4/A5.4M: 2012

E330-16

ASME SFA A5.4:

E330-16

TYPICAL APPLICATIONS

- Heat Treatment
- Furnace Environments
- Welding 330 stainless and similar materials

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	ED035004 ED035005 □
1/8	(3.2)	14	(355)		
5/32	(4.0)	14	(355)		

DEPOSIT COMPOSITION(1)

	%C	%Cr	%Ni	%Mo	%Mn
Requirements					
AWS E330-16	0.18 - 0.25	14.0 - 17.0	33.0 - 37.0	0.75 max	1.0 - 2.5
Typical Results(2)	0.21	15.5	34.3	0.13	1.7
	%Si	%P	%S	%Cu	FN
Requirements					
AWS E330-16	1.00 max	0.04 max	0.03 max	0.75 max	Not Required
Typical Results(2)	0.49	0.02	0.003	0.06	-

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 E330-16				
DC+/AC	40 - 80	75-110	95 - 150	130 - 200