



Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925

# 330-16 Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



### ALLOY DESCRIPTION AND APPLICATION;

Washington Alloy 330 electrodes have a high nickel content which gives the weld deposit the capability to provide excellent corrosion and oxidation resistance at extreme temperature ranges above 1800°F. However high sulfur environments may affect the high temperature performance. The weld deposit of 330 will exhibit high creep strength, excellent thermal shock resistance and minimal embrittlement. 330 electrodes are used for welding cast and wrought forms of AISI 330 stainless steel as well as with furnace and heat treatment applications. Low Heat input shall be used.

### TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps	Diameter	Amps
1/16"	15-40	1/8"	75-110
5/64"	30-50	5/32"	100-140
3/32"	50-75	3/16"	160-200

Arc Length = short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

### TYPICAL WIRE CHEMISTRY RANGE (%) & WELD METAL PROPERTIES

	AWS RANGE	330-16		AWS RANGE	330-16
Carbon	0.18-0.25	0.20	Tensile Strength (psi)	75,000 min.	85,500 psi
Manganese	1.0-2.5	2.1	Yield Strength (psi)		57,450 psi
Silicon	1.00 max	0.62	Elongation	25 % min.	32%
Molybdenum	0.75 max	0.05			
Nickel	33.0-37.0	34.7			
Chromium	14.0-17.0	15.7	Phosphorus	0.04 max	0.013
Copper	0.75 max	0.03	Sulfur	0.03 max	0.011

**AVAILABLE SIZES:** TF 330-16 = 3/32, 1/8, 5/32

Other sizes available – please inquire

**SPECIFICATIONS;**    **ANSI/AWS A5.4**    E330-16  
                                  **ASME SFA 5.4**        E330-16



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**EAST COAST**  
7010-G Reames Rd  
Charlotte, NC 28216  
Tel (888) 522-8296  
Fax (704)598-6673

**GULF COAST**  
4855 Alpine Drive #190  
Stafford, TX 77477  
Tel (877) 711-9274  
Fax (281)313-6332

**WEST COAST**  
8535 Utica Ave  
Rancho Cucamonga, CA 91730  
Tel(800)830-9033  
Fax (909)291-4586

Warehouse Distribution Center – Dayton, Ohio

Head Office – Puyallup, Washington

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