

Tech-Rod® 330

AWS E330-16

CONFORMANCES

AWS A5.4 E330-16

ASME SFA-A5.4 E330-16



Tech-Rod® 330 electrodes are used to weld wrought and cast forms of stainless steels of similar chemical compositions, which offer good heat and scale resistance to 1800°F (980°C). However, high sulfur environments adversely affect the high temperature performance. The heat input must be kept to a minimum during welding to avoid the possibility of micro-fissuring.

Applications: Heat treatment, Furnace environments

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Tube 24 lb (10.9 kg) Master Carton	10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton
3/32 (2.4)	12 (305)	EL33016093632	
1/8 (3.2)	14 (355)		EL33016125634
5/32 (4.0)	14 (355)		EL33016156634

DEPOSIT COMPOSITION

	%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 Tech-Rod® 330	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 Tech-Rod® 330	0.49	0.02	0.003	0.06	–

* Nitrogen in these weld deposits is usually between 0.04% and 0.08%

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Amperage	
		Flat	Vertical & Overhead
3/32 (2.4)	12 (305)	70-85	65-75
1/8 (3.2)	14 (355)	85-110	80-90
5/32 (4.0)	14 (355)	110-140	100-120

Material Safety Data Sheets (MSDS) are available on our website at www.techalloy.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

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