

EXCALIBUR® 385-16

Stainless • AWS E385-16



KEY FEATURES

- The weld metal is fully austenitic
- Minimal heat input welding procedures should be used to avoid solidification cracking

CONFORMANCES

AWS A5.4/A5.4M: 2006: E385-16

ASME SFA A5.4: E385-16

TYPICAL APPLICATIONS

- Welding 904L Stainless Steels
- Papermill Equipment
- Chemical process equipment
- Used in fabrication of equipment and vessels for handling and storage of sulfuric acid and phosphoric acid

WELDING POSITIONS

All, except vertical down

DIAMETERS / PACKAGING

Diameter		Length		8 lb (3.63kg) Easy Open Can	10 lb (4.5 kg) Easy Open Can
in	(mm)	in	(mm)	24 lb (10.89kg) Master Carton	30 lb (13.6 kg) Master Carton
3/32	(2.4)	12	(305)	ED036502	
1/8	(3.2)	14	(355)		ED035010
5/32	(4.0)	14	(355)		ED035011

DEPOSIT COMPOSITION(1)

	%C	%Cr	%Ni	%Mo	%Mn
Requirements					
AWS E385-16	0.03 max	19.5 - 21.5	24.0 - 26.0	4.2 - 5.2	1.0 - 2.5
Typical Results(2)	0.02	20.4	24.9	4.8	1.4
	%Si	%P	%S	%Cu	FN
Requirements					
AWS E385-16	0.90 max	0.03 max	0.02 max	1.2 - 2.0	Not Required
Typical Results(2)	0.34	0.01	0.01	1.6	-

TYPICAL OPERATING PROCEDURES

	Current (Amps)			
Polarity	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
E385-16				
DC+/AC	40 - 80	75-110	95 - 150	130 - 200