



WA. ALLOY CO.

WASHINGTON ALLOY'S Quality
Management System is
Certified to **ISO 9001:2008**
Cert # 05-R0925

USA 316H-16 Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

USA 316H electrodes produce weld deposits similar to that of USA 316, but with a 0.04-0.08 % carbon. This carbon content gives the weld deposit provides higher tensile and creep strengths at elevated temperatures. USA 316H electrodes are used for welding 18% Cr – 12% Ni – 2.5% Mo stainless steels where the corrosion resistant qualities of AISI 316H are required. This electrode has a high deposition rate and produces a weld deposit with fine bead appearance and good crack-resistance. USA 316H electrodes are most commonly used in the textile, paper, cellulose, and chemical equipment industries for the fabrication of 316H, 318 and 319H stainless steel products.

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.
When welding vertical reduce amperage 10-20%

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.055	Molybdenum	2.36
Manganese	1.05	Phosphorus	0.015
Silicon	0.58	Sulfur	0.012
Chromium	18.76	Nickel	12.20
	Elongation		41%
	Yield Strength (psi)		65,000
	Tensile Strength (psi)		86,000

Iron balance and all single values are maximum percentages

AVAILABLE SIZES: TF316H-16

SPECIFICATIONS; ANSI/AWS A5.4 E316H-16
ASME SFA 5.4 E316H-16

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

GULF COAST
4755 Alpine Drive #100A
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

Washington Alloy Company believes that all information and data given is correct. Use this information to assist in making your own evaluations or decisions and this information should not be mistaken as an expressed or implied warranty. U.S. ALLOY CO. assumes no liability for results or damages incurred from the use of any information contained herein, in whole or in part.