



330 AC-DC

AWS E330-16

REPLACES: 020501

160-J, INDEX: 060215

DESCRIPTION:

330 AC-DC is primarily used for heat and creep resisting applications with Type 330 base metal. It has a smooth running arc that results in a uniform bead that is flat to slightly convex.

Note: Actual certs are included in every master carton of stainless stick electrodes at no charge.

FEATURES BENEFITS

- | | |
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| <ul style="list-style-type: none"> • Spray-like arc transfer • Electrode doesn't overheat • Directional arc • Easy strike and re-strike • All-position | <ul style="list-style-type: none"> • Low spatter and less clean-up • Less stub loss, cost-effective • Metal goes where directed • Easy to use, less chance of starting defects • Welds extremely well in flat, horizontal, vertical (up) and overhead positions • Less chance of slag inclusions • Extends shelf life of product in open environments |
| <ul style="list-style-type: none"> • Easy slag release • Extremely high moisture resistance | |

TYPICAL WELD METAL PROPERTIES* (CHEM PAD):

WELD METAL ANALYSIS		AWS Spec
Carbon (C)	0.20	0.18 to 0.25
Manganese (Mn)	1.84	1.0 to 2.5
Phosphorus (P)	0.017	0.04 max
Sulphur (S)	0.015	0.03 max
Silicon (Si)	0.34	0.90 max
Copper (Cu)	0.20	0.75 max
Nickel (Ni)	34.19	33.0 to 37.0
Chromium (Cr)	15.30	14.0 to 17.0
Molybdenum (Mo)	0.10	0.75 max

TYPICAL MECHANICAL PROPERTIES*(AS WELDED):

		AWS Spec
Tensile Strength	86,000 psi (593 MPa)	80,000 psi
Yield Strength	58,000 psi (400 MPa)	not required
Elongation % in 2"	40%	35%
DeLong Ferrite Number Range	0	not required
Schaeffler Number Range	0	not required
WRC Number Range (1992)	0	not required

CONFORMANCES AND APPROVALS:

- AWS Spec A5.4, Class E330-16 • ASME SFA5.4

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and McKay expressly disclaims any liability incurred from any reliance thereon. Typical data are obtained when welded and tested in accordance with AWS A5.4 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by McKay.



330 AC-DC

RECOMMENDED WELDING PROCEDURES:

- GENERAL:** DCEP (electrode positive, work negative) or AC
ARC LENGTH: Short (less than half the diameter of the electrode)
FLAT & HORIZONTAL: Angle electrode 10°-15° from 90°
VERTICAL-UP: Use weaving techniques. Reduced amperage compared to flat position setting
OVERHEAD: Use slight weaving motion within the puddle
STORAGE: AC-DC electrodes have a high degree of moisture resistance; however, for critical applications, the electrode should be held at 225°F after opening
RECONDITIONING: If exposed to atmosphere for extended periods, recondition at 500°F for one (1) hour

RECOMMENDED OPERATING PARAMETERS:

DIAMETER		TYPE OF POWER	Flat & Horizontal		
INCHES	MM		MINIMUM AMPS	OPTIMUM AMPS	MAXIMUM AMPS
3/32	2.4	DCEP or AC	45	65	80
1/8	3.2	DCEP or AC	55	105	120
5/32	4.0	DCEP or AC	65	140	170
3/16	4.8	DCEP or AC	160	170	205

AVAILABLE DIAMETERS AND PACKAGES:

DIAMETER INCHES	DIAMETER MM	LENGTH		6-LB. CAN	10-LB. CAN
		INCHES	MM		
3/32	2.4	10	254	S480530-032	—
1/8	3.2	14	355	—	S480544-033
5/32	4.0	14	355	—	S480551-033
3/16	4.8	14	355	—	S480558-033

Material Safety Data Sheets on any McKay product may be obtained from McKay Customer Service.

Because McKay is constantly improving products, McKay reserves the right to change design and/or specifications without notice.