

Exaton 383-16



383-16 is a covered electrode of AWS 383-16 type with rutile-basic coating and normal metal recovery for welding of high-alloy austenitic stainless steels of UNS S08028 (e.g. Sanicro 28) and Alloy 825 type (e.g. Sanicro 41).

383-16 is suitable for joining highly alloyed fully austenitic stainless steels, such as EN 1.4563 (Sanicro 28) and Alloy 825 (Sanicro 41), which have high corrosion resistance in sulfuric and phosphoric acids and excellent pitting resistance in acid solutions containing chlorides and fluorides, such as sea water.

This electrode can be used for surfacing mild and low alloy steels to give protection against pitting corrosion in chloride-containing solutions.

Classifications	SFA/AWS A5.4 : E383-17 EN ISO 3581-A : E 27 31 4 Cu L R Werkstoffnummer : 1.4563
Approvals	CE EN 13749

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Ferrite Content	FN 0
Alloy Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	427 MPa (62 ksi)	612 MPa (89 ksi)	38 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	66 J (49 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.025	0.90	0.8	0.006	0.018	32	27	3.5	0.9	0.07

Typical Weld Metal Analysis %

Co
0.060

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	40-95 A	30 V	87	33 sec	60 %	1.2 kg/h (2.6 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	55-125 A	30 V	45	50 sec	60 %	1.6 kg/h (3.5 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	70-185 A	31 V	30	48 sec	61 %	2.5 kg/h (5.5 lb/h)