Stainless Steel BARE WIRE DATA SHEET

executive 330

DESCRIPTION

Executive 330 is commonly used where heat and scale resisting properties above 1800°F (980°C) are required, except in high sulfur environments, as these environments may adversely affect elevated temperature performance. Repairs of defects in alloy castings and the welding of castings and wrought alloys of similar composition are the most common applications.

Being a fully austenitic alloy, care must be taken to minimize heat input during welding in order to reduce the potential for cracking.

TYPICAL CHEMICAL VALUES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.2	16.0	35.5	0.1	1.9	0.4	0.01	0.01	0.75

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.093	29 - 32	300 - 350	20 - 30 IPM	Record IN Flux
	.125	29 - 32	400 - 550	20 - 30 IPM	Record IN Flux
GMAW	.035	29 - 33	160 - 180	30 - 50 CFH	98/99% Ar + 2/1% O_2
	.045	29 - 33	180 - 220	30 - 50 CFH	or
	.062	29 - 33	210 - 250	30 - 50 CFH	97% Ar + 3% CO_2
GTAW	.093	Direct Current; Electrode –		30 - 40 CFH	100% Ar

MECHANICAL PROPERTIES

Tensile Strength:	84,000 PSI	580 MPA
Yield Strength:	56,500 PSI	390 MPA
Elongation:	29%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.9, Class ER330.** ISO 14343A, Class 18 36 H and ISO 14343B, Class SS330.