

DESCRIPTION

Executive 320LR provides superior weldability, low spatter and smooth beads with easy slag removal. Has good corrosion resistance in acidic environments.

Weld metal deposited by Executive 320LR electrodes has the same basic composition as that deposited by E320 electrodes; however, the elements C, Si, P, and S are specified at lower maximum levels, and Nb and Mn are controlled within narrower ranges. These changes reduce the weld metal fissuring (while maintaining the corrosion resistance) frequently encountered in fully austenitic stainless steel weld metals. Consequently, welding practices typically used to deposit ferrite-containing austenitic stainless steel weld metals can be used.

APPLICATIONS & FEATURES

Suitable for welding process piping, heat exchangers, welding alloy 20 and similar materials and chemical processing plants.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

| C | Si | Mn | P | S | Cr | Ni | Mo | Cu | Cb+Ta | |
|--------------------------|------|----------------|-------|------------------------|-------|----------------|------|--------------------|-------|-----|
| 0.027 | 0.16 | 1.97 | 0.018 | 0.005 | 19.64 | 32.13 | 2.21 | 3.45 | 0.32 | |
| Tensile Strength: | | 85,000 PSI min | | Yield Strength: | | 57,000 PSI min | | Elongation: | | 34% |

TYPICAL WELDING PARAMETERS

| Process | Diameter | Length | Amperage |
|---------------|----------|--------|----------|
| SMAW AC/DC | 3/32" | 12" | 40-70 |
| | 1/8" | 14" | 60-100 |
| | 5/32" | 14" | 90-140 |
| | 3/16" | 14" | 120-185 |

STANDARD PACKAGING & HANDLING

| | |
|------|--------------------|
| SMAW | 40-lb master box |
| | 10-lb plastic tube |

CLASSIFICATION

AWS/SFA 5.4, Class **E320LR**

