Techalloy® 330

AWS ER330

CONFORMANCES

AWS A5.9 ER330

UNS N08331

ISO 14343: 2009 (18 69 H)[e]

Techalloy® 330 electrodes are used to weld wrought and cast forms of stainless steels of similar chemical compositions, which offer good heat and scale resistance to 1800°F (980°C). However, high sulfur environments adversely affect the high temperature performance. The heat input must be kept to a minimum during welding to avoid the possibility of micro-fissuring.

Applications: Heat treatment, Furnace environments

DIAMETERS / PACKAGING

Diameter in	(mm)	MIG WIRE 33 lb (14.9 kg) Wire Basket	TIG 10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton
0.035	(0.9)	MG330035667	
0.045	(1.2)	MG330045667	
3/32	(2.4)		TG330093638
1/8	(3.2)		TG330125638

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DEPOSIT COMPOSITION

	%C	%Cr	%Ni	%Mo	%Mn
Requirements AWS ER330	0.18 - 0.25	15.0 - 17.0	34.0 - 37.0	0.75 max.	1.0 - 2.5
Typical Performance Techalloy® 330	0.23	15.9	35.2		1.9
	%Si	**%P**	**%S**	**%Cu**	
Requirements AWS ER330	0.30 - 0.65	0.03	0.03	0.75 max.	
Typical Performance Techalloy® 330	0.42	0.01	0.005	0.10	

TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Gas Flow	Gas
MIG	0.035 (0.9) 0.045 (1.2)	26-29 28-32	160-210 180-250	30-50 CFH	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO_2
TIG	3/32 (2.4) 1/8 (3.2)		120-175 150-220	20-40 CFH	100% Argon

Material Safety Data Sheets (MSDS) are available on our website at www.techalloy.com

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