

### DESCRIPTION

Executive 320LR wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 320LR (Low Residuals) has Carbon, Silicon, Phosphorus and Sulfur specified at lower maximum levels and the Niobium and Manganese are controlled at narrower ranges.

Executive 320LR narrow chemistry range reduces the likelihood of weld metal hot cracking and fissuring frequently encountered in fully austenitic stainless-steel weld metals.

### APPLICATIONS & FEATURES

Executive 320LR is used in tanks, heat exchangers, process piping, vessel manufacturing, overlay, cladding, and general manufacturing and fabrication.

Executive 320LR is an ideal choice for corrosion resistance in highly acidic environments.

### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	Nb
0.007	20.02	32.95	2.40	1.81	0.09	0.008	0.001	3.40	0.0192	0.27
<b>Tensile Strength:</b>		86,000 PSI min		<b>Yield Strength:</b>		54,500 PSI min		<b>Elongation:</b>		35%

### TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
<b>GMAW</b> - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO <sub>2</sub> or 1%-5% O <sub>2</sub> /Balance Ar	
	.045"	22-23	180-210			
	.062"	23-24	200-220			
	- Spray	.035"	23-25			190-260
		.045"	25-28			250-330
		.062"	28-31			310-350
<b>GTAW</b>	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
<b>SAW</b>	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

### STANDARD PACKAGING

<b>GMAW</b> (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
<b>GTAW</b> (TIG)	10-lb plastic tube	40-lb box
<b>SAW</b>	60-lb wire coil	1,200-lb pallet

### CLASSIFICATION

AWS/SFA 5.9, Class **ER320LR**

