

DESCRIPTION

Executive 330 provides superior weldability, low spatter and smooth beads with easy slag removal.

Commonly used where heat- and scale-resisting properties above 1800°F (980°C) are required. However, high sulfur environments may adversely affect performance at elevated temperature. Repairs of defects in alloy castings and the welding of castings and wrought alloys of similar compositions are the most common applications.

APPLICATIONS & FEATURES

Suitable for welding similar metals, furnaces and heat treatment. Generally used for resistance to oxidation at elevated temperatures.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Ni	Mo
0.21	0.50	1.95	0.021	0.021	15.40	34.10	0.52

Tensile Strength: 85,000 PSI min **Yield Strength:** 56,500 PSI min **Elongation:** 27%

TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
SMAW	3/32"	12"	40-70
AC/DC	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 **E330-16**



