

DESCRIPTION

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

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.

APPLICATIONS & FEATURES

Executive 330 is used for joining stainless steel with similar composition often used in furnace applications, as well as repairs in alloy castings.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	
0.22	15.96	34.92	0.20	1.38	0.39	0.021	0.008	0.22	
Tensile Strength:		84,000 PSI min						Elongation: 29%	
Yield Strength:		56,500 PSI min							

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045"	24	130	225	100% CO ₂ or Ar + 20-25% CO ₂
.045"	27	175	320	
.045"	30	240	530	
.062"	27	195	152	100% CO ₂ or Ar + 20-25% CO ₂
.062"	31	260	260	
.062"	34	320	360	

*Shielding gas flow rate 35 to 50 CFH. For 100% CO₂ use two volts higher than shown

STANDARD PACKAGING

FCAW 33-lb plastic spools 1,980-lb pallet

CLASSIFICATION

AWS/SFA 5.22, Class **EC330**

