

DESCRIPTION

Executive 330 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 330 has an austenite structure with 15% Cr-35% Ni. It is widely used for heat resistant and oxidation resistant applications above 980°C. In fully austenitic welds maintaining a low heat input is critical to avoid hot cracking.

APPLICATIONS & FEATURES

Executive 330 is used in repairing alloy castings and welding AISI 330 castings and forgings.

Executive 330 is 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.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	
0.213	15.82	36.01	0.38	1.42	0.48	0.011	0.001	0.03	0.020	
Tensile Strength:		85,600 PSI min		Yield Strength:		56,600 PSI min		Elongation:		30%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /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
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

STANDARD PACKAGING

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



CLASSIFICATION

AWS/SFA 5.9, Class **ER330**