

Inweld 330

AWS A5.9 ER330

Chemical Composition of Inweld 330

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.18- 0.25	15.0- 17.0	34.0- 37.0	0.75	1.0- 2.5	0.30- 0.65	0.03	0.03	---	0.75

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 330 is used to weld cast and wrought material of similar chemical composition. The weld metal provides excellent scale and heat resistance up to 1800°F. Inweld 330 is a fully austenitic alloy therefore heat input is necessary. High sulfur environments may adversely affect temperature performance.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	84,000 psi
Yield Strength:	56,500 psi
Elongation:	29%

Recommended Parameters

GMAW (DCEP – Electrode +)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Wire Feed IPM</u>
0.023"	14-19	30-85	180-400
0.030"	15-20	45-125	150-350
0.035"	16-22	60-150	120-330
0.045"	17-22	90-210	100-280

GTAW (DCEN – Electrode -) 100% Ar 2% Thoriated

<u>Filler Wire Size</u>	<u>Tungsten</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Argon (CFH)</u>
1/16"	1/16"	10-12	80-150	20
3/32"	3/32"	15-18	150-250	20
1/8"	1/8"	16-20	200-375	25

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