



320LR XM

AWS A 5.9: ER320LR
W.Nr. 2.4660

DESCRIPTION

Solid welding wire primarily used for welding of 20Cb-3 type stainless steels. C, Si, P and S are all controlled at lower maximum levels and Nb and Mn are controlled within narrower ranges than ER320 to avoid hot cracking and fissuring. This alloy has excellent resistance to general corrosion, pitting, and crevice corrosion in chemicals containing chlorides and sulfuric, phosphoric, and nitric acids. It also contains niobium for stabilization against sensitization and resultant intergranular corrosion. Typical applications: Food, process piping, chemical industry, petrochemical, pharmaceutical etc.

WELDING POSITIONS



CURRENT

DC+

GAS

Ar / Co₂ (M12)

BASE MATERIALS

20Cb-3, Alloy 20, Carpenter 20

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
>520	>300	>25	

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Mo	Nb	Ni	Si
<0,025	1,5-2,0	<0,15	19,0-21,0	2,0-3,0	0,2-0,4	32-36	<0,15
Cu	S	P					
3,0-4,0	<0,02	<0,015					

PACKAGING

Dimension(mm)	0,8	1,0	1,2	
Spool size(kg)	15	15	15	

EQUIVALENT FILLER METALS

TIG	Meltolit 320LR XT
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