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Inox 330

High Temperature
Stainless Steel Electrode


FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
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Classification

AWS A5.4 : ~ E330-15
ISO 3581-A : Z 18 35 B 42

EN 1600 : Z 18 35 B 42

Description & Applications

Basic coated electrode with an austenitic stainless steel deposit with 18 % Cr, 35 % Ni and an increased carbon content. Used to weld austenitic heat resistant alloys and castings resisting to scaling and oxidation up to 1100 °C.

Regular and stable fusion, good slag removal, nice aspect of the bead.

Principal applications: Petrochemical industry, for furnaces, for heat treatment equipments , etc.

Base materials

Stainless and high temperature steels:

UNS	Alloy	EN	Material N°
N08330	330	X12NiCrSi36-16	1.4864
	DS	X8NiCrSi38-18	1.4862

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni
0.2	0.5	3.5	18.0	35.0

All Weld Metal Mechanical Properties

Rp0.2 (MPa)	Rm (MPa)	A5 (%)
> 450	> 600	> 20

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	100	135

Rebaking at 250°C during 2 hours, if necessary.

Interpass temperature : < 150°C.



1G/PA

2F/PB

2G/PC

3G/PF

4G/PE

= +

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