

GM 320

IDENTIFICATION

GM 320, ER 320

CLASSIFICATION

AWS/SFA-5.9 ER320

DESCRIPTION

Solid wire which gives fully austenitic niobium stabilized weld deposit. The wire contents low level of S, Si, P & S which reduces hot cracking tendency and fissuring. The wire gives a low carbon nil ferrite “super-austenitic” weld metal with good resistance to attack by a range of organic and inorganic acids, sulphuric and minerals acids etc.

Deposited weld metal which is fully austenitic, has controlled level of phosphorus and silicon which helps to eliminate solidification cracking tendency.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
0.07	2.5	0.6	0.03	0.03	19.0 - 21.0	32 - 36	2.0 - 3.0	3.0 - 4.0	8XC% min or 0.40 max
max	max	max	max	max					

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)
550 min	30 min

TYPICAL APPLICATIONS

- Tanks
- Process piping
- Heat exchangers
- Agitators & Rotosa
- Cast Pump
- For use in the chemical processing, metal cleaning & pickling industries.

WELDING CURRENT : DC (-)

SHIELDING GAS : 98% Ar + 2% Oxygen

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5
1	12.5
1.2	12.5