RATNA 320

A fully austenitic stainless steel electrode with Nb stabilized, together with Mo and Cu.

CLASSIFICATION : AWS/SFA-5.4: E 320-16

CHARACTERISTICS : A fully austenitic stainless steel electrodes weld metal is 20 Cr, 34 Ni, 2.50 Mo, 3.50 Cu with Nb added to improve resistance to inter-granular corrosion. These alloying are primarily used to weld base metals of similar composition for applications where resistance to severe corrosion is required.

APPLICATION :

1) Suitable for a wide range of chemicals including sulfuric and sulfurous acids and their salts.
2) Welding can be used to weld both castings and wrought alloys.
3) Materials to be welded, ASTM A351.A 744 Grade CN-7M, BS 1504-332 C 11 Carpenter 20, 20cb, 20 cb-3 and similar properties alloys.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Cu	Mo	Nb
0.07	0.50 – 2.50	0.60	0.030	0.040	19.0 - 21.0	32.0 - 36.0	3.00- 4.00	2.0 - 3.0	8 x C min. to 1.0 max

Single value maximum

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm^2)	ELONGATION %
550 Min.	30 Min.

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/AC) Amps	Kg / Packet	Kg / Case
2.50/ 2.40	3/ 32”	70-100	2	10 / 20
3.15/ 3.20	1/ 8”	90-130	2	10 / 20
4.00	5/ 32”	120-160	2	10 / 20
5.00	3/ 16”	160-200	2	10 / 20

Tailor made packing available on request.