

GEN 330 Welding Wire and Rod

GEN 330 is used to weld cast and wrought alloys of similar chemical composition. The weld metal has outstanding heat and scale resisting properties up to 1800°F (980°C), except in high-sulfur environments, as these environments may adversely affect high temperature performance. Due to its austenitic microstructure, low heat input during welding is necessary.

CONFORMANCES

AWS A5.9/A5.9M	:	ER330
ASME SFA-A5.9	:	ER330
UNS	:	N08331

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.18 – 0.25	15.0 – 17.0	34.0 – 37.0	0.75 max	1.0 – 2.5
0.22	16.5	35.1	0.13	1.8
%Si	%P	%S	%Cu	
0.30 – 0.65	0.03 max	0.03 max	0.75 max	
0.58	0.015	0.01	0.05	

TYPICAL WELD METAL MECHANICAL PROPERTIES

Tensile Strength	:	84,000 psi	579 MPa
Yield Strength	:	56,000 psi	386 MPa
Elongation	:	28 %	

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 17	90 – 130	100% Ar
	3/32"	2.4 mm	15 – 20	120 – 175	100% Ar
MIG (GMAW)	.035"	0.9 mm	29 – 33	160 – 190	98%Ar – 2%O ₂
	.045"	1.1 mm	29 – 33	180 – 220	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	2.4 mm	29 – 32	300 – 350	
	.125"	3.2 mm	29 – 32	400 – 550	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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