



330 Welding Wire and Rod

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925



ALLOY DESCRIPTION AND APPLICATION;

Washington Alloy 330 stainless a high nickel content which gives the weld deposit the capability to provide excellent corrosion and oxidation resistance at extreme temperature ranges above 1800°F. The weld deposit of 330 will exhibit high creep strength, excellent thermal shock resistance and minimal embrittling. Washington Alloy 330 used for welding cast and wrought forms of AISI 330 stainless steel.
(Tri-mix gas = 90%He+7.5%Ar+2.5%CO₂)

TYPICAL GMAW WELDING PROCEDURES; DCEP Short Circuit

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out	Tri-mix (cfh)	
0.023	180-400	30-85	14-19	3/8-1/2"	20-25	
0.030	150-350	45-125	15-20	3/8-1/2"	20-25	
0.035	120-330	60-150	16-22	3/8-1/2"	20-30	
0.045	100-280	90-210	17-22	3/8-1/2"	25-30	
<i>Spray 0.030</i>	<i>280-600</i>	<i>160-220</i>	<i>24-28</i>	<i>3/8-1/2"</i>	<i>(1)25-35</i>	(1) 98%Ar 2%O ₂
<i>0.035</i>	<i>250-470</i>	<i>170-295</i>	<i>23-29</i>	<i>1/2-3/4"</i>	<i>(1)25-35</i>	
<i>0.045</i>	<i>200-385</i>	<i>195-360</i>	<i>24-30</i>	<i>1/2-3/4"</i>	<i>(1)30-35</i>	
<i>1/16"</i>	<i>110-200</i>	<i>210-380</i>	<i>25-31</i>	<i>1/2-3/4"</i>	<i>(1)35-40</i>	

TYPICAL GTAW WELDING PROCEDURES; DCEN with EWTh-2 truncated conical tip

Filler Wire Size	Tungsten	Amps	Volts	Gas Cup Size	Argon (cfh)	Base thickness
1/16"	1/16"	80-150	12	3/8"	20	1/16-1/8"
3/32"	3/32"	150-250	12	3/8"	20	1/8- 3/16"
1/8"	1/8"	200-375	12	1/2"	25	1/4-1/2"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WIRE CHEMISTRY RANGE (%) & WELD METAL PROPERTIES from AWS A5.4

Carbon	0.20	Tensile Strength (psi)	75,000 min.
Manganese	1.75	Elongation	25 % min.
Silicon	0.35		
Molybdenum	0.75 MAX		
Nickel	35.1	Phosphorus	0.01
Chromium	15.95	Sulfur	0.005
Copper	0.11		

AVAILABLE SIZES: TS 330 = Spools of 035, 045
TT 330 = Cut lengths of 035, 045, 1/16, 3/32, 1/8
Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.9 ER330
ASME SFA 5.9 ER330

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