

TECH-ROD 330

- I. **DESCRIPTION:** Tech-Rod 330 electrodes are used to weld wrought and cast forms of stainless steels of similar chemical composition, which offer good heat and scale resistance above 1800°F (980°C). However, high sulfur environments adversely affect the high temperature performance. The heat input has to be kept to a minimum during welding to avoid the possibility of micro fissuring. The impurities and low melting constituents are kept to minimum to eliminate cracking.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.4 Class E330-16.

III. **CHEMICAL COMPOSITION**

Carbon	.21
Manganese	1.9
Silicon	.48
Chromium	15.45
Nickel	34.4
Sulfur	.023
Phosphorus	.021
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength	
84,500 PSI	580 MPA
Yield Strength	
57,000 PSI	390 MPA
Elongation	26%

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can