



D&H 320 (NS)

CODIFICATION : AWS : SFA 5.4 E320-16

CHARACTERISTICS AND APPLICATIONS :

D&H 320 (NS) is a rutile type non-synthetic all position electrode depositing 20Cr - 35Ni - 2.5Mo - 3.5Cu - Nb weld metal. The weld metal has excellent resistance to oxidation and scaling at 1200°C continuous service. Quiet and stable arc. Less spatter loss good bead appearance with equal ripples. It is primarily used to weld base metals of similar composition for applications where resistance to severe corrosion is required for a wide range of chemicals including sulfuric and sulfurous acid and their salts. These electrodes can be used to weld both castings and wrought alloys of similar composition without post weld heat treatment. The typical applications include HV-9A stainless steel, for fabricating carpenter 20 stainless steels etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb + Ta
Percent:	0.05	1.20	0.40	0.020	0.020	20.5	35.0	2.50	3.5	0.55

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L = 4d)%
590	33.0

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 150-180	110-140	80-100	60-80
Weight/Carton (kgs)	: 2.5	2.5	2.5	2.5

PRECAUTIONS :

1. Ensure the electrodes are dry. In case of moisture pick-up, re-dry the electrodes at 250-300°C for one hour.
2. Use short arc, stringer bead, and smallest possible size of electrode and min. current to reduce the heat input.

Note: D&H 320-15 (NS) conforming to AWS E320-15 is also available.