

CODIFICATION: AWS/SFA 5.9: ER320

CHARACTERISTICS AND APPLICATIONS:

FW 320 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. The weld metal provides resistance to intergranular corrosion. Ideally suited to weld base metal of similar composition for applications where resistance to severe corrosion involving a wide range of chemicals, including sulfuric and sulfurous acids and their salts, is required. It can be used to weld both castings and wrought alloys of similar composition.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb+Ta
Percent	0.02	1.75	0.35	0.010	0.012	20.0	34.0	2.5	3.5	0.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d) %
580	36.0

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITION : H, F, VU, OH

PACKING:

STANDARD SIZE	Diameter 1.6 mm 2.0 mm, 2.50 mm & 3.20 mm in cut lengths of 1000 mm each.
QUANTITY	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire.

An ISO 9001: 2008 certified company

D & H Sécheron Electrodes Pvt. Ltd.

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