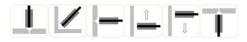
GMAW Solid Wire for Stainless Steel					
	Classification				
KMC 220	AWS	S A5.9/A5.9	V ER330		
KMS-330	JIS	Z3321	YS330		
	EN	14343-A	G 18 36 H		
Shielding Gas: Ar+1~2%O <sub>2</sub> (CO <sub>2</sub> )	YB	T5092	H21Cr16Ni35		

# **Applications and Features**

- (1) Weld metal is austenitic structure with 16%Cr-35%Ni.
- (2) Used to weld wrought and cast forms of stainless steels of similar chemical compositions, which offer good heat and scale resistance to 980°C.
- (3) Ideal for repairing defects in alloy castings and welding AISI 330 castings and forgings.

## **Welding Position**



## Welding Instruction

(1) Use Ar+1~2%O<sub>2</sub> for spray transfer and Ar+1~2%CO<sub>2</sub> for short-circuit transfer.

(2) For other instructions, please refer to Appendix B and F.

## Typical Chemical Composition of Weld Metal (wt%)

с	Si	Mn	Р	S	Cr	Ni	Мо
0.23	0.43	1.90	0.012	0.009	16.02	35.42	0.23

## **Typical Mechanical Properties of Weld Metal**

Tensile Strength	Yield Strength	Elongation	
N/mm²	N/mm <sup>2</sup>	%	
590	390	30	

## Size and Suggested Operating Range (DC+)

Diamete	er (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Ar+1~2%CO <sub>2</sub>	Current (A)	40~120	60~140	80~160	100~210	-	-
	Voltage (V)	15~20	15~21	16~22	17~22	-	-
Ar+1~2%O <sub>2</sub>	Current (A)	160~210	170~260	180~280	200~300	210~320	220~330
	Voltage (V)	24~28	24~30	24~30	24~30	24~32	24~32