

## GMAW Solid Wire for Stainless Steel

# KMS-320LR

### Classification

AWS A5.9/A5.9M ER320LR

JIS Z3321 YS320LR

EN 14343-A -

YB T5092

H019Cr20Ni34Mo2Cu3Nb

Shielding Gas: Ar+1~2%O<sub>2</sub>(CO<sub>2</sub>)

### Applications and Features

- ( 1 ) Weld metal is austenitic structure with 20%Cr-34%Ni-2.5%Mo-3.5%Cu-Nb.
- ( 2 ) Weld metal provides exceptionally good corrosion resistance to a wide range of chemical environments.
- ( 3 ) Ideal for welding similar metals in wrought and cast forms, such as Alloy 20..

### 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%)

C	Si	Mn	P	S	Cr	Ni	Mo	Nb	Cu
0.01	0.08	1.71	0.011	0.001	19.81	32.89	2.39	0.25	3.33

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%
600	430	39

### Size and Suggested Operating Range (DC+)

Diameter (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