



S. R. Industries

STAR ARC ER320LR

ER320LR has a composition similar to type 320, except that carbon, silicon, phosphorus, and sulfur levels are kept at lower levels as well as the columbium and manganese being specified at a narrower range. The low melting residuals are limited in this alloy to reduce the possibility of microfissuring. It is for this reason that this alloy is often used for welding type 320 stainless steels.

AWS Specification : AWS A5.9/A5.9M:2006

AWS Classification	ER320LR
Welding Current	DCEP
Typical Wire Chemistry	
C	0.025
Cr	19.0 - 21.0
Ni	32.0 - 36.0
Mo	2.0 - 3.0
Mn	1.5 - 2.0
Si	0.15
P	0.015
S	0.02
Cu	3.0 - 4.0
Nb	8xCmin/0.40max
Typical Mechanical Properties (As Welded)	
Yield Strength, ksi	57
Tensile Strength, ksi	86
Elongation%, min	35

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<i>Welding Positions</i>	<i>F,V,OH,H</i>
<i>Available Diameters MIG with Operating Range in Amps</i>	
<i>.023"</i>	<i>35 - 70</i>
<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>160 - 210</i>
<i>.045"</i>	<i>180 - 250</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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