

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY330

● Applicable Specification

JIS Z 3221 ES330-16
AWS A5.4 E330-16

● Identification Color

End Face: Brown
Side Face:—

● Applications and Characteristics

TASETO RNY330 is used for welding of 35%Ni-15%Cr stainless steel such as AISI 330. It exhibits excellent corrosion resistibility, oxidation resistibility and high strength at high temperature.

RNY330 is a lime-titania type electrode of good usability in positional welding.

● Notes on Usage

- * Dry the electrode at 150°C to 200°C for 60 minutes before use.
- * Avoid excessively high current or wide weaving to prevent hot cracking.
- * Clater treating is necessary.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.21	0.57	2.07	0.021	0.013	34.66	15.11	0.07	0.04

● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)
Typical	595	34.4

● Typical Mechanical Properties of All Weld Metal in Elevated Temperatures

Temperature (°C)	Tensile Strength (MPa)
550	477
650	414
700	385
750	382

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—