

Solid Wire Electrode for Submerged Arc Welding

BA-WIRE 320LR

Classification: SFA-5.9 – ER320LR

Typical analysis and chemical composition acc. to AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	Nb	P	S	Cu total
Typical analysis BA-WIRE 320LR	0.015	0.1	1.6	2.5	34.20	19.70	0.25	0.010	0.009	3.5
ER320LR acc. to AWS A5.9	0.025	0.15	1.5–2.0	2.0–3.0	32.0–36.0	19.0–21.0	8x%C–0.40	0.015	0.02	3.0–4.0

Application:

BA-WIRE 320LR is a submerged arc welding wire intended for welding steels of similar composition in wrought and cast forms. BA-WIRE 320LR has composition similar to ER320, except that carbon, silicon, phosphorus and sulphur levels are kept at a lower level. The low melting residuals are limited in this alloy to reduce micro-fissuring. The weld metal provides exceptionally good corrosion resistance to a wide range of chemical environments.

Base Materials:

- ER320 stainless steels.
Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire electrode surface:

Smooth finish free from surface defects and foreign matter.