

Specifications:

AWS A5.9
 AWS Class ER321
 ASME SFA 5.9
 UNS S32180

Minimum Mechanical Properties:

Tensile Strength: 75,000 psi
Yield Strength: 30,000 psi
Elongation: 40%

Description:

ER321 is a filler metal that is made to weld Chromium-Nickel steels of similar composition. ER321 has the addition of titanium, which allows for an increase in its resistance to intergranular corrosion.

Available in multiple sizes and diameters in spool and wire rods.

Chemical Composition (Wt%):

Si	Mn	Cu	Mo	S	Ni	Cr	P	C	Ti
0.30-0.65	1.0-2.5	0.75	0.75	0.03	9.0-11.0	18.5-20.5	0.03	0.08	(9 x C) min – 1.0 max

Note: Single values are maximum unless otherwise noted.

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.