

Gas Tungsten Arc Welding

MS T-321 Filler Rod for Stainless Steel

Applications Suitable for welding of 321 stainless steel. With Titanium added. The Titanium acts in the same way Nb(Cb) in type 347 and thus increasing resistance to intergranular corrosion

Brand Name		MS T-321							
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	Ti
	≤ 0.08	≤ 0.65	1.0 - 2.5	≤ 0.03	≤ 0.03	9.0-10.5	18.5-20.5	-	9xC-1.0
Mechanical property of deposited metal									
Tensile strength	≥ 540 N/mm ²								
0.2% Offset strength	≥ 225 N/mm ²								
Elongation	≥ 30 %								
Impact test	NA								
Welding position	All position								
Welding polarity	DC-EN								
Shielding gas	Ar								
Welding current	Dia. 1.2 mm		Dia. 1.6 mm			Dia. 2.4 mm			
	30-80 A		40-120 A			50-150 A			
Packing									
Inner case weight (kg)	5.00								