


CATEGORY	GMAW Solid wires																
TYPE	Solid stainless steel wire for high corrosive environments																
APPLICATIONS	CEWELD 320 (Alloy 20) is used in a variety of industries, including chemical processing, petrochemical and refining, marine, pharmaceutical and food processing. End use applications include storage tanks, mixing tanks, agitators, pump and valve parts, food processing equipment, fasteners and fittings.																
PROPERTIES	CEWELD 320 was designed specifically to withstand sulfuric acid. Its nickel, chromium, molybdenum and copper levels all provide excellent general corrosion resistance. Restricted carbon plus columbium stabilization permits welded fabrications to be used in corrosive environments, normally without post-weld heat treatment. At 33% nickel, CEWELD 320 has practical immunity to chloride stress corrosion cracking. This alloy is often chosen to solve SCC problems, which may occur with 316L stainless																
CLASSIFICATION	AWS EN ISO F-nr FM W.Nr.	A 5.9: ER320 14343-B: G 320 6 5 2.4660															
SUITABLE FOR	2.4660, AISI 320 UNS N08020 Alloy 20, Carpenter 20, 320, Microfer 3620 nb, Carpenter 20, Incoloy 20, NiCr20CuMo																
APPROVALS	CE																
WELDING POSITIONS:																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.06</td> <td>0.5</td> <td>1.6</td> <td>20</td> <td>34</td> <td>2.5</td> <td>3.5</td> </tr> </tbody> </table>			C	Si	Mn	Cr	Ni	Mo	Cu	0.06	0.5	1.6	20	34	2.5	3.5
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WELDING PARAMETERS / PACKING																	
REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175	M13																