

RA330® is readily welded using RA330-04 weld fillers. RA330-04 weld fillers have special elemental additions to avoid hot cracking when welding RA330. Do not use AWS ER330 weld fillers as they have a matching composition and are prone to hot cracking. RA330-04-15 DC lime type electrodes are available from stock in popular sizes. RA330-04 bare welding wire is available as straight lengths for GTAW welding or spooled for GMAW welding. For best results do not preheat, keep interpass temperature low and use reinforced bead contours. Further guidelines for welding RA330 can be found in our RA330 welding manual.

Specifications

RA330-04 UNS: N08334

Chemical Composition, %

	Cr	Ni	Si	Mn	P	S	C	Fe
RA330-04	19.0	35.0	0.8	5.25	—	—	0.25	balance

Features

- High strength
- Excellent resistance to thermal shock
- Good resistance to thermal cycling

Applications

- Wrought radiant tubes
- Retorts
- Muffles
- Corrugated Boxes

Availability

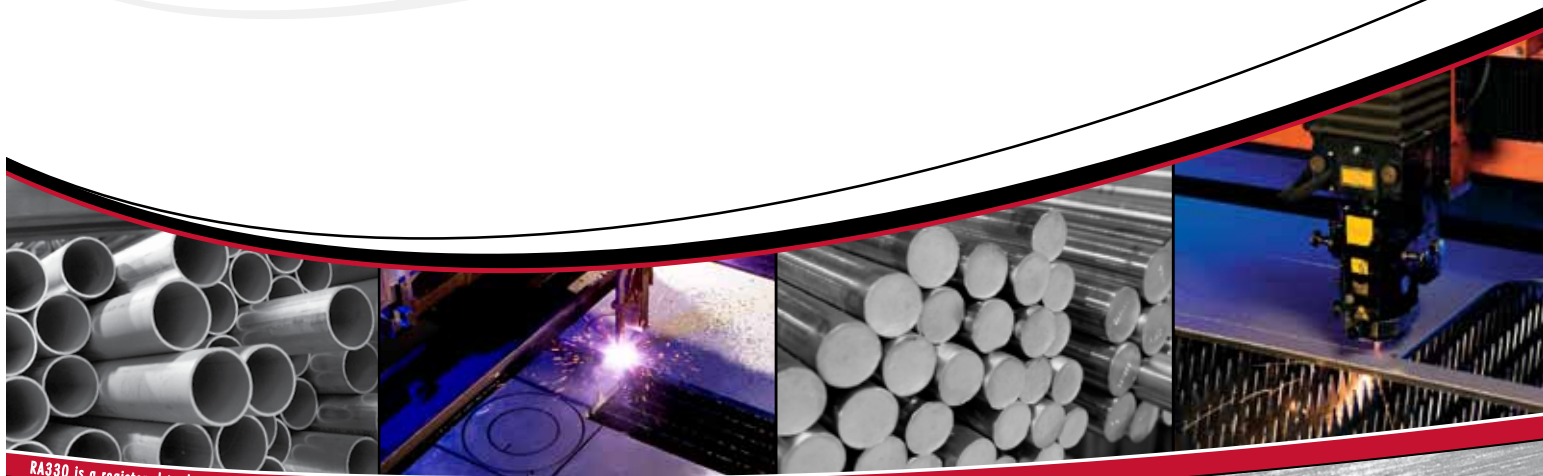
RA330-04

GMAW	Diameter, in	0.035	0.045					
GTAW	Diameter, in	0.035	0.045	0.063	0.093	0.125		
Electrode	Diameter, in				0.093	0.125	0.15625	0.1875

Mechanical Properties

Typical Tensile Properties

Hardness Max, HRB	85
-------------------	----



RA330 is a registered trademark of Rolled Alloys

