

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

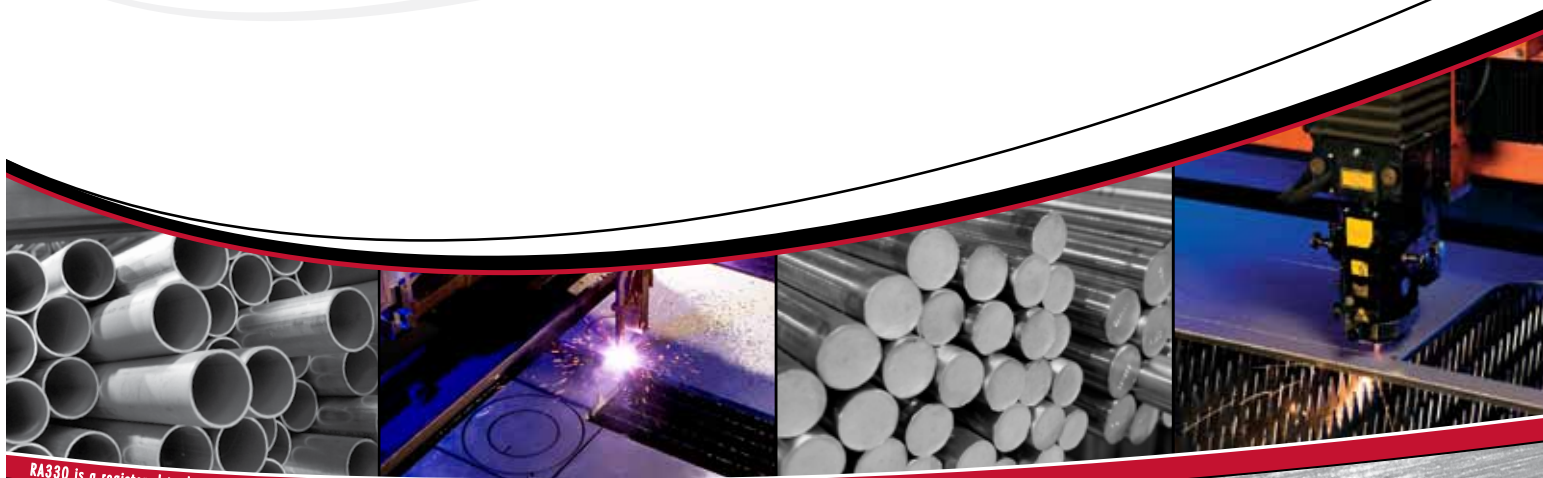
**RA330-04**

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
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