

UNITED STATES WELDING CORPORATION

USW ALLOY DESIGNATION AND DESCRIPTION	GTAW SOLID	BALOY® 35 MC-GRADE BARE WELDING IRON BASE EN STRENGTHEN	WIRE	AS 9100 Revision	0	DATA SHEET 5774
CROSS-REFERENCE CONFORMANCE SPECIFICATIONS	AMS 5774 USWC 5774 (V) UNS S35080 16.5Cr 4.5Ni 2.9Mo 0.10N AM350 AISI 633					
METALLURGICAL BACKGROUND INFORMATION	TURBALOY® 350 wire is produced by special lubricant-free, roller-die forming followed by surface abrasion and cleaning processes. These manufacturing processes ensure consistent physical purity of the welding wire surface. TURBALOY® 350 is a nitrogen strengthened hardenable stainless alloy with austenitic or martensitic structure depending on thermal cycle. The filler metal is used to fabricate base alloys of similar composition. PWHT at 1650°F is recommended for optimum properties.					
MATERIALS TO BE WELDED AND APPLICATIONS	AMS 5745, 5546, 5548, 5554. UNS S350000. ASTM A579. Turbine compressor components. (AMS 5825 can be used to weld Alloy AM350.) AMS 5774 is also used to weld AM 355.					
WIRE CHEMISTRY WT%	Carbon Manganese Silicon Sulfur Phosphorus	0.08 0.12 0.50 1.25 - 0.50 - 0.030 - 0.040		4.00 denum 2.50	17.00 5.00 3.25 0.13 Bala	
WELD PROPERTIES	Melting range: 25 Hardness annealed Hardness hardened		Density: 7.92 gm/cc			
SIZES AND FORMS AVAILABLE	5 lb. (2.2kg) packs 36" (914mm) leng Flag tagged for tra (Double tagging at Wide range of diar	Pro 12 8" uest) on W	SPOOLED WIRE Precision layer wound, with controlled cast and helix 12" (300mm) diameter spools standard 8" (200mm), 4" (100mm) and proprietary spool sizes on request. Wide range of diameters and spool weights.			
PACKAGING	Sealed, air-evacuated, argon purged Vapor Barrier e nvelopes with desiccants ensure full protection from atmospheric contamination and prolonged shelf-life.					
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