

Flux Cored Welding Wire

K-329T

Duplex Stainless welding wire (22%Cr-9%Ni-Mo)

Classifications

EN ISO 17633-A:2010 : T 22 9 3 N L P C1/M21 1
EN ISO 17633-B:2010 : TS 2209-F C1/M21 1

AWS A5.22-2012 : E2209T1-1/4
JIS Z 3323-2007 : TS2209-FB1

Description

- K-329T is formulated for MAG welding of 23%Cr-9%Ni-3%Mo duplex stainless steel and this principal area of application is chemical plant and shipbuilding as well as nuclear plant industries (ASTM A185 Gr.51, UNS S31803, DIN 1.4462, JIS 329J1)
- Wire is a titania type of flux cored wire for all-position welding and It has a stable welding arc producing a weld with easy slag removal and minimal spatter.
- K-329T is excellent in pitting corrosion resistance and stress corrosion cracking resistance.

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂,
Mix: Ar+20% CO₂ (15~25l/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Mo	PREN	FN
CO ₂	0.03	0.52	0.80	23.20	9.60	3.20	37	36.7
Mix	0.03	0.54	0.85	23.40	9.60	3.30	38	36.8

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-40°C	
AWS A5.22		min. 690	min. 20			
EN ISO 17633-B	min. 350	min. 690	min. 15			
Example	715	818	27	52	42	CO ₂
	720	825	26	50	40	Mix

Notes on usage and welding condition

- Refer to page 313 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		

Approvals

ABS, DNV*GL, LR, JIS

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.