

80%Ar - 20%CO₂/100%CO₂
 EN ISO 17633-A T 22 9 3 N L R C/M 3
 AWS A5.22 E2209T0-1/-4
 1.4462

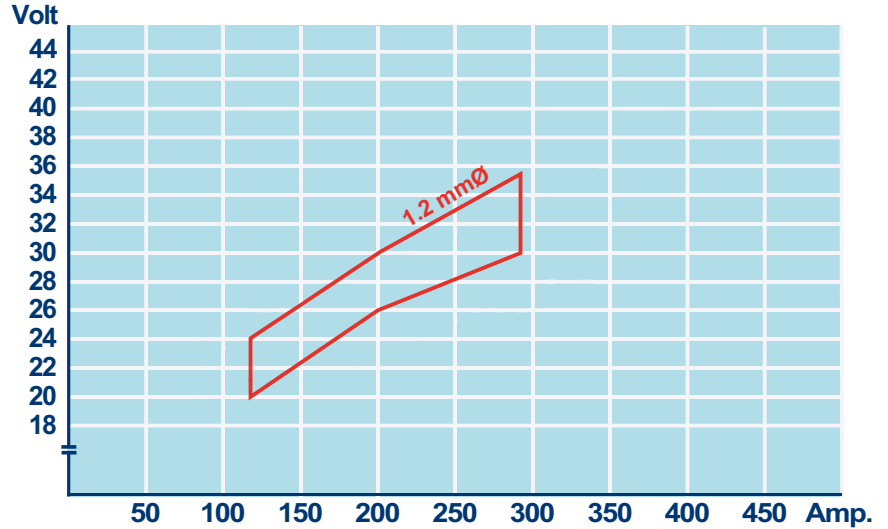
80%Ar - 20%CO₂/100%CO₂
 EN ISO 17633-AT 22 9 3 N L P C/M 1
 AWS A5.22 E2209T1-1/-4
 1.4462

Description and Application

These are rutile flux cored wires which operate with very stable, spatter free arcs producing bright, smooth weld bead surfaces.

These wires are designed for welding duplex stainless steel such as AISI S31803 or EN 1.4462 stainless steels. Due to the high nitrogen and high molybdenum in their weld metals, it is possible to obtain excellent resistance to chloride induced pitting corrosion.

Recommended Parameter Range, for flat position



Note: The above parameters are typical range for DW-329A with mixed gas. Adjust voltage for 100% CO₂ and DW-329AP.

Chemical Analysis

	C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FNW
DW-329A	0.03	0.75	0.97	0.019	0.006	9.3	23.3	3.4	0.14	-	49.0
DW-329AP	0.03	0.58	0.78	0.019	0.008	9.4	22.9	3.5	0.15	-	42.7

Mechanical Properties

	R _e (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	CV (J)-20°C	CV (J)-46°C
DW-329A	656	850	29	49	43
DW-329AP	670	850	29	45	40

Welding Positions

DW-329A
1.2mm



DW-329AP
1.2mm



Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-329A	S31803	Nograde	-	-	-	-	TÜV
DW-329AP	S31803	Nograde	-	4462S	-	-	RINA, TÜV