

DW-<u>329AP</u>

80%Ar - 20%CO. EN ISO 17633-A T 22 9 3 N L P M21 1 AWS A5.22 E2209T1-4 EN 1.4462

Description and Application

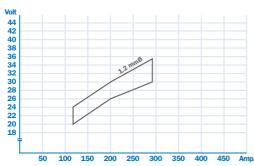
This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces.

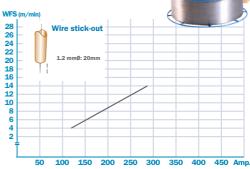
This wire is designed for welding duplex stainless steel such as AISI S31803 or EN 1.4462 stainless steels.

Due to the high nitrogen and high molybdenum levels in the weld metal, it is possible to obtain excellent resistance to chloride induced pitting corrosion.



Recommended Parameter Range, for flat position*





Typical Chemical Analysis (wt. %)*

С	Si	Mn	Р	S	Ni	Cr	Мо	N	Nb	FNW
0.03	0.58	0.78	0.019	0.008	9.4	22.9	3.5	0.15	-	42.7

Typical Mechanical Properties*

