CARBO F- 329

Standards

EN 12073	T 22 9 3 N L R M 3	T 22 9 3 N L R C 3
ASME IIC SFA 5.22 / AWS A 5.22	E2209T0-4	E2209T0-1

Characteristics

CARBO F-329 is a rutile flux cored stainless steel wire which produces a low carbon duplex stainless steel deposit.
Exceptional resistance to moisture pick up.
Attractive bead appearance, very good penetration and high productivity.
Excellent X-ray soundness.
Maximum performances in the horizontal and downhand positions.
Can be used out of position.
Welded with classical economical Ar-CO_2 mixtures or CO_2.

Typical applications

Welding wrought, forged or cast duplex stainless steels for service in the as-welded condition.
Heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels.

Typical mechanical properties

Rm[Mpa]	Rp0.2%[Mpa]	A%	KCV [J]
830	670	28	40 at -20°C

Examples:

UNS	Material number	EN Symbol
S31803	1.4462	X2CrNiMoN 22-5-3
S32205	1.4462	
S32304	1.1462	X2CrNiN 23 4

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Mo	Ni	N	S	P
0,03	0,8	1,3	22,7	3,2	9,1	0,16	0,008	0,020

Gas types EN 439 M21 gas mixtures (Ar + 5 – 25% CO_2) or C1 (CO_2)

Current **= +**

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	23 - 35	100 - 270	**G**
1,6	1/16	23 - 37	150 - 400	**G**

Delivering form

O = **Flux cored wire self shielding**
G = **Flux cored wire for shielded arc welding**
S = **Flux cored wire for submerged arc welding**

Coiling / Weight B/BS 300 = 15 kg

Rev. 000