

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-CO₂ mixtures or CO₂.

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% CO₂) or C1 (CO₂)

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

Rev. 000

B/BS 300 = 15 kg

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.