

# K-329T

AWS E2209T1-1/4

FOR STAINLESS STEEL

## Typical applications

K-329T is formulated for MAG welding of 23%Cr-9%Ni-3%Mo duplex stainless steels. The 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)

## Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② It has a smooth stable arc producing a weld with easy slag removal and minimal spatter.
- ③ K-329T is excellent in pitting corrosion resistance and stress corrosion cracking resistance.
- ④ The shielding gas should be used 100%CO<sub>2</sub> and 80%Ar+20%CO<sub>2</sub> for welding.
- ⑤ Refer to page 150 for more information on usage.

## Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Ni	Mo	N
CO <sub>2</sub>	0.03	0.49	1.67	23.1	9.6	2.8	0.11
Ar+20%CO <sub>2</sub>	0.03	0.62	1.83	23.3	9.5	2.8	0.11

## Typical mechanical properties of all-weld-metal

Shielding Gas	T · S		EI (%)
	N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }		
CO <sub>2</sub>	816 {83}		27
Ar+20%CO <sub>2</sub>	823 {84}		27

## Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	1.2		1.6	
	F	H	F	H
Amp.	H	100~240	F	160~260
	V	120~200	H	160~220

## Welding positions



Approved by

ABS, JIS