

ER329N

SAW

SOLID WIRE FOR SAW

PRODUCT DESCRIPTION

Duplex stainless steel wire suitable for 1.4462 base material and similar grades
Recommended with P2007 and P2000 fluxes

CLASSIFICATIONS

AWS A5.9M	ER2209
ISO 14343-A	S 22 9 3 N LL
ISO 14343-B	SS2209
Approvals	TÜV, ABS, LR

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 9
Mat. Nr.	1.4462

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
Min.	--	1.0	0.25	--	--	22.5	8.0	3.0	--	0.14
Max.	0.03	2.0	0.65	0.020	0.030	23.5	9.5	3.5	0.3	0.20
Typical	0.015	1.6	0.5	0.001	0.015	23	8.2	3.2	0.1	0.17*

Duplex weld metal microstructure with austenite + 30-50% ferrite.

Pitting resistance equivalent PREN = Cr + 3.3Mo + 16N is > 35.

* ER329N MIG spooled wire is selected for suitability for both MIG and auto-TIG, with typically 0.15%N to control porosity.

ALL-WELD MECHANICAL PROPERTIES

As welded	Min.	Typical SAW + SSB	Typical SAW + P2007
Tensile strength (MPa)	690	790	780
0.2% proof strength (MPa)	450	630	600
Elongation (%) 4d	20	30	29
5d	20	27	27
Impact ISO-V(J) -30°C	--	75 [>55]	70 [>50]
-50°C	--	55 [>35]	50 [>35]
-75°C	--	--	--
Hardness HV	--	275 (< 320)	275 (< 320)
HRC	--	23 (< 28)	23 (< 28)

TYPICAL OPERATING PARAMETERS

Flux	Current	Diameter (mm)	Parameters
SSB	DC+	2.4	350A, 30V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	25	B415	598797
3.2	25	B415	598780
4.0	25	B415	598781