

# GRIDUR F-29W

## TOP FEATURES

- Cr-Mo-W-Ni alloying system
- 310-370 HB, 33-40 HRC
- Applicable for stress relieving at 520 °C

## TYPICAL APPLICATIONS

- Maintenance and Repair

## CLASSIFICATION

EN 14700 T Fe8

## CURRENT TYPE

DC+

## WELDING POSITIONS

Flat/Horizontal

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ (>15-25%) CO<sub>2</sub>  
 Flow rate 15-25 l/min

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	P	S	Si	Cr	Ni	Mo	V	W
0.09	0.7	max 0.030	max 0.025	0.5	4.7	0.9	2.3	0.6	2.3

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Hardness
Typical values	AW	34 HRC
	SR 10h/520 °C	34 HRC

\* AW = As welded; SR = Stress relieved

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.0	SPOOL	20.0	81242620

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.