ER329N

TOP FEATURES

- 0,15%N content to control porosity
- PREN>35

CLASSIFICATION

AWS A5.9M	ER2209
EN ISO 14343-A	W 22 9 3 N L
EN ISO 14343-B	SS2209

APPROVALS

ABS, DNV, TÜV

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
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.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Units	Min.	Typical
Tensile strength	Mpa	690	790
0.2% Proof strength	Mpa	450	620
Elongation 4d	%	20	36
Elongation 5d	%	20	33
Impact ISO-V @ -30°C	J	-	180 (> 140)
Impact ISO-V @ -50°C	J	-	180 (> 120)
Impact ISO-V @ -75°C	J	-	125 (>70)
Hardness	HV	-	270 (< 310)
Hardness	HRc	-	23 (< 28)

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
1.6	PE Tube	5.0	TER329N-16
2.4	PE Tube	5.0	TER329N-24
3.2	PE Tube	5.0	TER329N-32

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 for any updated information.