ER329N SAW

TOP FEATURES

- 0,15%N content to control porosity
- Recommended to be used with P2000 or SSB flux
- Supplied in 25kg precision layer wound spools

CLASSIFICATION

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

CURRENT TYPE

DC+

APPROVALS

ABS	LR	TÜV
+	+	+

CHEMICAL COMPOSITION (WEIGHT %), WIRE

	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.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

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)
Hardness	**(HV)**		275 (< 320)	275 (< 320)
	(HRc)		23 (< 28)	23 (< 28)

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.4	SPOOL	25.0	SAER329N-24
3.2	SPOOL	25.0	SAER329N-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.