ER329N MIG

TOP FEATURES

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

CLASSIFICATION

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

SHIELDING GASES (ACC. EN ISO 14175)

I3	Inert gas Ar+ 0.5-95% He
C1	Active gas 100% CO_2

APPROVALS

DNV	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
Tensile strength	**(MPa)**	690	800-835
0.2% Proof strength	**(MPa)**	450	560-620
Elongation	**4d**	20	28-35
	5d	20	30
Impact ISO-V (J)	**- 30°C**		> 70
	- 50°C		> 60
	- 75°C		
Hardness	**HV**		270 (< 310)
	HRc		23 (< 28)

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
0.8	SPOOL (S300)	15.0	MER329N-08
0.9	SPOOL (S300)	15.0	MER329N-09
1.0	SPOOL (S300)	15.0	MER329N-10
	DRUM	250.0	MER329ND-10
1.2	SPOOL (S300)	15.0	MER329N-12

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.