

ER329N MIG

TOP FEATURES

- 0,15%N content to control porosity

TYPICAL APPLICATIONS

- Offshore
- Petrochemical and chemical process plants

CLASSIFICATION

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

APPROVALS

DNV, TÜV

SHIELDING GASES (ACC. EN ISO 14175)

I3	Inert gas Ar+ 0.5-95% He
C1	Active gas 100% CO ₂

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	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.

* 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

	Condition	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)		Impact ISO-V (J)		Hardness	
				4d	5d	-30 °C	-50 °C	(HV)	(HRC)
Required: AWS A5.9		450	690	20	20	-	-	-	-
Typical values	AW	560-620	800-835	28-35	30	70	60	270	23

AW = As welded

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (S300)	15.0	MER329N-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.