

## Flux Cored Welding Wire

# K-329T

Duplex Stainless welding wire (22%Cr-9%Ni-Mo)

### Classifications

EN ISO 17633-A:2010 : T 22 9 3 N L P C1/M21 1  
EN ISO 17633-B:2010 : TS 2209-F C1/M21 1

AWS A5.22-2012 : E2209T1-1/4  
JIS Z 3323-2007 : TS2209-FB1

### Description

- K-329T is formulated for MAG welding of 23%Cr-9%Ni-3%Mo duplex stainless steel and this principal area of application is chemical plant and shipbuilding as well as nuclear plant industries (ASTM A185 Gr.51, UNS S31803, DIN 1.4462, JIS 329J1)
- Wire is a titania type of flux cored wire for all-position welding and It has a stable welding arc producing a weld with easy slag removal and minimal spatter.
- K-329T is excellent in pitting corrosion resistance and stress corrosion cracking resistance.

### Welding positions



### Polarity & shielding gas

- CO<sub>2</sub>: 100% CO<sub>2</sub>,  
Mix: Ar+20% CO<sub>2</sub> (15~25l/min)
- DCEP (DC+)

### Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Mo	PREN	FN
CO <sub>2</sub>	0.03	0.52	0.80	23.20	9.60	3.20	37	36.7
Mix	0.03	0.54	0.85	23.40	9.60	3.30	38	36.8

### Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-40°C	
AWS A5.22		min. 690	min. 20			
EN ISO 17633-B	min. 350	min. 690	min. 15			
Example	715	818	27	52	42	CO <sub>2</sub>
	720	825	26	50	40	Mix

### Notes on usage and welding condition

- Refer to page 313 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

### Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		

### Approvals

ABS, DNV\*GL, LR, JIS

\* Please refer to our homepage([www.kiswel.com](http://www.kiswel.com)) for further detailed information regarding approvals.