DW-329AP PREMIARC™

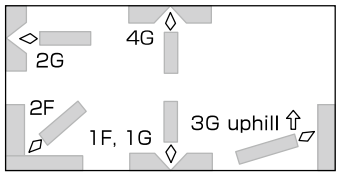
Flux cored wire

Features: ▪ Suitable for normal duplex stainless steel (S32205, S31803, etc)

Classification: AWS A5.22 E2209T1-1/4

Shielding gas: CO_2 or Ar-CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (wire mass%)

	Typical (Ar-CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.61	1.0
Mn	0.74	0.5~2.0
P	0.02	0.04
S	0.01	0.03
Ni	9.10	7.5~10.0
Cr	22.70	21.0~24.0
Mo	3.30	2.5~4.0
Cu	0.02	0.75
N	0.13	0.08~0.20

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical (Ar-CO_2)	Guaranty
0.2%YS (MPa)	639	-
TS (MPa)	820	690min.
El on 4d (%)	28	20min.
IV -20℃ (J)	46	-

Approvals

	CO_2	Ar-CO_2
ABS	MG (AWS A5.22 E2209T1-1)	MG (AWS A5.22 E2209T1-4)
LR	S31803S (CHEM), Dup/CMnS(CHEM)	S31803S (CHEM)
DNV	MG (Duplex)	MG (Duplex)
BV	SA2205	SA2205
NK	KW2209G (C)	KW2209G (M21)
CCS	2205	2205

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill	4G
1.2	130~250	150~220	130~220	160~190