

# WEL AutoTIG 329J4L

EN ISO 14343 A 2007 W 25 9 4 N L



## Solid wire for welding of Super duplex mechanized TIG- or Plasma-process.

### General description:

TIG-wire on spools for welding of Super Duplex materials as SAF2507, Zeron 100 and similar. Normally, Argon or Argon/N<sub>2</sub> mix is used as the shielding gas. The wire is designed for automated/mechanized welding of both pipes and plates. Level of gas flow depends upon welding parameters, choice of gas and rate of cooling. "Purity" is the keyword when welding high alloyed materials. Impurities in the weld, will cause porosity.

Welding of pipes require use of purge gas in order to ensure a stainless root face of the weld. Please contact us for further details on purge equipment. Inter-pass temperature should not exceed 150°C, and heat input should not exceed <1.5kJ/mm.

### Welding positions:



### Current:

DC -

### Gas flow:

10 – 20 l/min

### Typical chemical composition of all-

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	N	Nb	W		
Max 0,03	Max 1,00	Max 2,50	Max. 0,03	Max. 0,02	Max 1,5	8,0-10,5	24,0-27,0	2,50-4,50	0,2-0,3	-	Max 1,0		

### Shielding gas:

Shielding gas: Ar, Ar+N<sub>2</sub> Purge gas: Ar, Ar+N<sub>2</sub>, N<sub>2</sub>

### Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V -46°C	
≥550	≥800	≥25	≥45 J	

### Ferrite content:

WRC	De long	Schaeffler	Cr+3,3xMo+16xN
			Min. 41/Typical 42,5

### Packing information:

1,0mm x 12,5kg D300  
1,2mm x 12,5kg D300

### Approvals:

### Reference./date:

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