

NST 329J3L XLT Duplex

AWS A5.22/A5.22M E2209T1-4

NS-EN ISO 17633-A: T 22 9 3 N L P M21 1

EN ISO 9606-1: FM5



Flux cored wire for all-round welding of Duplex materials such as SAF 2205 and EN 1.4462.

General description:

The NST 329J3L XLT Duplex is a rutile flux cored wire for welding of Duplex materials such as SAF 2205, EN 1.4462 and UNS 31803.

The wire can be used in all welding positions and gives very good properties at very low temperatures down to -60 °C.

Shielding gas is Argon/CO₂ mixed gas.

This enables a user friendly and stable welding arc, less spatter, good visual bead appearance and smooth transition to the parent material.

The newly developed slag system gives the welder better control of the weld pool in all positions. NST 329J3L XLT is also suitable for use with ceramic backing for single sided welding.

Welding positions:



Welding current:

DC+

Gas flow:

15-23 l/min

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N
0.021	0.49	1.25	0.021	0.002	0.06	9.0	22.5	2.8	0.13

Shielding gas:

Argon+18-25% CO₂.

Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %	Charpy V (J) -46 °C	Charpy V (J) -60 °C
640	806	26	48	43

Guidance - Ampere (DC+):

Electrode diameter			
Ampere / Volt			

Packaging information:

1.2mm x 12.5kg D300
1.2mm x 5 kg D200

Approvals:

CE

Reference / date:

NST 329J3L XLT Duplex,
English, 12.09.2025.