

WEL TIG 329J4L

EN ISO 14343-A 2007 W 25 9 4 N L



The TIG-rod which gives you documented Super duplex properties.

General description:

WEL TIG 329J4L is used for welding of Super Duplex materials as SAF2507, Zeron 100 and similar.

Normally, Argon or Argon/N₂ mix are used as the shielding gas.

The TIG-rod is used for manual welding of both pipes and plates. Level of gas flow depends upon the TIG-rod diameter and the specific application.

The balance of Austenite and Ferrite in the weld metal will depend upon welding parameters, choice of gas and rate of cooling. The TIG-rods are supplied colour coded in green and with the brand name embossed,

according to the requirements of the NORSOK standard.

"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+N₂ Purge gas: Ar, Ar+N₂, N₂

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:

1,6mm x 500mm x 2,5Kg / 1,6mm x 1000mm x 5kg
 2,0mm x 500mm x 2,5Kg / 2,0mm x 1000mm x 5kg
 2,4mm x 500mm x 2,5Kg / 2,4mm x 1000mm x 5kg

Colour coding: Green

Approvals:

Reference./date:

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