

# TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

## GFW329J4L

Applicable Specification  
JIS Z 3323 TS329J4L-FC0

### ● Applications and Characteristics

TASETO GFW329J4L is used for welding of duplex stainless steel such as SUS329J4L. As weld metal has higher pitting resistance equivalent (PRE<sup>\*</sup>) value than that of GFW329J3L, GFW329J4L is suitable for more corrosive environment.

※ PRE = Cr% + 3.3xMo% + 16xN%

### ● Notes on Usage

\* Preheating is not necessary and interpass temperature should be kept under 150°C.

\* Post weld heat treatment causes severe embrittlement of weld metal.

\* Use 100%CO<sub>2</sub> as shielding gas.

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	N	PRE
Typical	0.029	0.60	0.87	0.020	0.004	10.02	25.39	3.98	0.05	0.15	40.9

### ● Ferrite Content of All Weld Metal

WRC-1992 Diagram	
Typical	65 FN

### ● Tensile Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	700	873	25.0

### ● Impact Properties of All Weld Metal(Charpy 2mmV)

	Test Temp. (°C)	Absorbed Energy (J)	Lateral Expansion (mm)
Typical	0	32	0.42

### ● Corrosion Resistance of All Weld Metal

Typical	CPT in 6% Ferric Chloride Test (JIS G 0578)	35°C
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### ● Sizes Available and Shielding Gas

Size (mm)	Shielding Gas
1.2	CO <sub>2</sub> , 20L/min