

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY329J3L

● Applicable Specification

JIS Z 3221 ES2209-16
AWS A5.4 E2209-16

● Identification Color

End Face: Brown
Side Face:—

● Applications and Characteristics

TASETO RNY329J3L is used for welding of duplex stainless steel such as 2205. It exhibits excellent corrosion resistibility in industrial water containing chlorine ion in small concentration. Resistibility to stress corrosion cracking and pitting corrosion is excellent too. Hot cracking resistibility of the all weld metal is good.

RNY329J3L is a lime-titania type electrode of good usability in positional welding.

● Notes on Usage

* Dry the electrode at 150°C to 200°C for 60 minutes before use.

* Post weld heat treatment adversely affects embrittlement.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	N
Typical	0.025	0.37	0.79	0.027	0.007	8.58	21.60	2.93	0.12	0.12

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy (J)	
				0°C	-76°C
Typical	634	829	24.0	80.4	43.1

● Other Properties of All Weld Metal

* 5% Sulfuric Acid Test : max. 1 g/m²·h

* 65% Nitric Acid Test : max. 0.5 g/m²·h

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—