

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY329J4L

### ● Applicable Specification

JIS Z 3221 ES329J4L-16  
AWS A5.4 E2594-16

### ● Identification Color

End Face: Purple  
Side Face:—

### ● Applications and Characteristics

TASETO RNY329J4L is used for welding of duplex stainless steel such as SUS329J4L. It exhibits excellent corrosion resistibility in industrial water containing chlorine ion in small concentration. Resistibility to stress corrosion cracking, pitting corrosion and seawater corrosion is excellent more than RNY329J3L. Hot cracking resistibility of the all weld metal is good.

RNY329J4L 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	W
Typical	0.027	0.47	0.64	0.015	0.007	8.23	25.68	3.15	0.28	0.13	0.02

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	590	815	25.0

### ● Other Properties of All Weld Metal

- \* 5% Sulfuric Acid Test : max. 2 g/m<sup>2</sup>·h
- \* 65% Nitric Acid Test : max. 0.001 in/month (0.5g/m<sup>2</sup> · h)

### ● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—