

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GF329J3L

Applicable Specification
JIS Z 3323 TS2209-FC0
AWS A5.22 E2209T0-1

● Applications and Characteristics

TASETO GF329J3L is used for welding of duplex stainless steel such as Type 2205, UNS S31803, and lean duplex stainless steel such as UNS S32101, S32304. Weld metal has excellent resistibility to pitting corrosion and stress corrosion cracking. It has also resistibility to seawater and phosphate.

● Notes on Usage

- * Please refer "Guideline for Welding Stainless Steel with GF3 Wires".
- * Post weld heat treatment causes severe embrittlement of weld metal.
- * Use 100%CO₂ as shielding gas.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	N
Typical	0.029	0.47	0.88	0.018	0.005	9.10	23.38	3.25	0.03	0.13

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	577	790	30.0

● Corrosion Resistance of All Weld Metal

* Typical Corrosion Resistance	2.82 g/m ² ·h	(5% Sulfuric Acid Test)
	8.92 g/m ² ·h	(Ferric Chloride Test)

● Sizes Available and Shielding Gas

Size (mm)	Shielding Gas
1.2	CO ₂ , 20L/min
1.6	CO ₂ , 20L/min