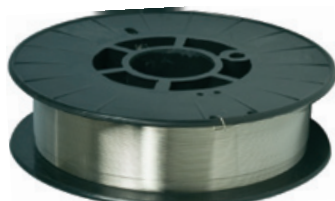


Technical Data Sheet

329M and 329M-FC MIG Wire



Cronatron™
A LAWSON BRAND

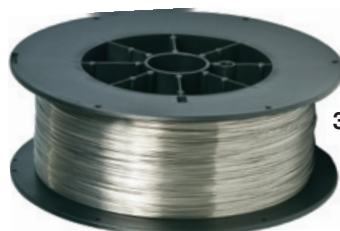


329M MIG Wire



Overview

These weld deposits are characterized by a relatively high ferrite number (FN), making them very resistant to hot cracking. Ideally suited for welding AISI 309 stainless steel to itself and welding the 300 Series stainless steels to carbon steels. These deposits have a stable microstructure up to 1,000°F (540°C) and both display excellent operability.



329M-FC MIG Wire

Features/Benefits

- Great wetting action
- Increased operability over 312 Grade stainless steel wires
- In-service temperatures up to 1,000°F (540°C)
- Excellent for joining stainless steels to carbon steels
- Available in small diameters for out-of-position welding
- Relatively high FN number for crack resistance

Applications

- Pipe lines
- Storage tanks
- Valves
- Hydroelectric components
- Stainless steel to carbon steel joints

Method of Application

MIG welder, DC reverse polarity

Identification

Labeled spool

Directions for Use

Remove all foreign materials, fatigued and cracked or spalled metal. Use DC reverse polarity and the recommended shielding gas. For joining, stringer beads are recommended. For hardfacing build-up, stringer or slight weave beads may be used. Unlimited build-up.

Technical Specifications

Tensile Strength: 95,000 PSI (655 MPa)
Yield Strength: 76,500 PSI (527 MPa)
Elongation: 33%
Ferrite Number: 17

Gas (329M): 90% He, 7.5% Ar, 2.5% CO₂ or
98% Ar, 2% O₂
Gas (329M-FC): 75% Ar, 25% CO₂

Technical Tips

For typical operating parameters refer to Product Information Report – Typical Operating Parameters.