

**Technical data sheet**

011121MBA

**Cored welding wire**  
**TUBE S 329-G****CLASSIFICATION**

EN ISO 17633-A: T Z 25 4 M M12 1  
 Equivalent Material number: 1.4820

**DESCRIPTION**

- Metal cored stainless steel wire for gas shielded arc welding
- 25% chromium - 4% nickel - heat resistant deposit
- Enhanced productivity, improved weldability, better wetting properties compared to solid wires
- Excellent weld metal quality and X-ray soundness

**APPLICATIONS**

TUBE S 329-G is suitable for high temperature applications where the nickel content of the filler material must be kept as low as possible. It is used for joining refractory Cr-Al-Si steels - as a general rule for stainless steels containing 8 to 24% chromium with silicon and/or aluminium additions - or for cladding corrosion resistant overlays.

**Examples:**

WNr	EN	ASTM/ACI	WNr	EN	ASTM/ACI
1.4710	G-X30CrSi6		1.4745	G-X40CrSi23	TP433
1.4712	X10CrSi6	502	1.4762	X10CrAl24	TP443
1.4713	X10CrAl7	502	1.4773	X8Cr30	
1.4722	X10CrSi13		1.4776	G-X40CrSi29	
1.4724	X10CrAl13	TP405-CA15	1.4820	G-X12 CrSi 26 5	
1.4729	G-X40CrSi13		1.4821	X20 CrNiSi 25 4	TP329
1.4740	G-X40CrSi17		1.4822	G-X40CrNi 25 4	TP329
1.4742	X10CrAl18	430B-TP430	1.4823	G-X40CrNiSi 27 4	TP329HC

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Cr	Ni	S	P
0.08	0.70	0.80	25.0	4.00	0.008	0.020

Typical ferrite level: 80 FN (The structure is essentially ferritic with intragranular austenite)

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
600	400	15	+20°C: 27

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
750	570	20	+ 20°C: 40

**SHIELDING GAS**

EN ISO 14175: M12 Ar + 0.5 % < CO<sub>2</sub> ≤ 2.5 with or without helium  
 Z Ar + CO<sub>2</sub> ≤ 0.5 % or O<sub>2</sub> ≤ 0.5 % with or without helium  
 I1 Ar  
 M13 Ar + 0.5 % < O<sub>2</sub> ≤ 3.0 with or without Helium

**OPERATING CONDITIONS**

Current type	Gas flow rate	Stick out	Recovery
DC+ / pulsed	10 - 20 l/min.	12 - 25 mm	98 %

**WELDING POSITIONS**

EN ISO 6947: PA, PB  
 ASME IX: 1G, 1F, 2F

TUBE S 329-G is primarily used in the flat and horizontal positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

**PACKAGING**

Diameter	1.2 mm		1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M		
Spool type	S200	BS300	BS300
Weight	5 kg	15 kg	15 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.