

## SACW 329

**CATEGORY** SAW Arc Submerged

**TYPE** High-alloyed tubular wire based on a 25% Chromium and 4% Nickel deposit .

**APPLICATIONS** - Cap layers for joining refractory Cr-Al-Si steels. - Cladding corrosion resistant overlays. - Cladding heat resistant overlays (1100°C) - Cladding components in a sulphurous environment.

**PROPERTIES** Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Attractive bead appearance without slag residues. Suitable for cladding and joining components against corrosion, high-heat and wear resistance. Weldable with the Sub-Arc process using Ceweld® Flux FL 880.

**CLASSIFICATION**

AWS	A 5.9:
EN ISO	14343:
DIN: W.Nr.	1.4820

**SUITABLE FOR** Cap layers for joining refractory Cr-Al-Si steels., cladding corrosion resistant overlays., Cladding heat resistant overlays (1100°C), Cladding components in a sulphurous environment. 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

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Ni	P	S
0.08	1.00	0.80	25.00	4.00	0.020	0.008

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		
				20°C	40°C	60°C
AW	570	750	20	40		

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	Spool type	kg / spool
1.6	28-30	250-350	Coil / Drum	25 / 330
2.4	29-32	350-450	Coil / Drum	25 / 330
3.2	29-32	350-550	Coil / Drum	25 / 330

**REDRYING TEMPERATURE** 150°C / 24hr