

Exaton 29.8.2.L

Exaton 29.8.2.L is used for MIG/MAG welding of the super-duplex grade Sandvik SAF 2906. Typical applications are welding of piping systems in Caustic soda production as well as welding of pipes and heat ex-changers in Alumina production. It can also be used for overlay welding using hot wire TIG and mechanical TIG.

Classifications Wire Electrode	EN ISO 14343-A : G Z 29 8 2 L
Alloy Type	Austenitic-ferritic (duplex) with approx. 50 FN ferrite - 29% Cr - 7% Ni - 2% Mo - Low C
Shielding Gas	I1, N2 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	150 J

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<0.025	1.0	0.4	0.0005	0.015	7	29	2.2	0.11	0.3

Typical Wire Composition %

Nb	Ti	Co	PRE
0.01	0.003	0.07	41.7

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)