

Exaton 29.8.2.L (GTAW)

Exaton 29.8.2.L is used for TIG welding of the super-duplex grade 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 is used for joining and overlay welding.

Specifications

Classifications	EN ISO 14343-A : W Z 29 8 2 L
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic-ferritic (duplex) with approx. 50 FN ferrite - 29% Cr - 7% Ni - 2% Mo - Low C
Shielding Gas	N ₂ (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	730 MPa (106 ksi)	880 MPa (128 ksi)	25 %
ISO			
As Welded	750 MPa (109 ksi)	870 MPa (126 ksi)	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C (68 °F)	165 J (122 ft-lb)
ISO		
As Welded	20 °C (68 °F)	180 J (133 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
ISO									
0.02	0.9	0.3	0.001	0.017	6.7	29	2.2	0.14	0.3
AWS									
0.016	0.9	0.3	0.001	0.017	6.7	29	2.2	0.14	0.2

Typical Weld Metal Analysis %

Nb	Ti	Co	PRE
ISO			
0.003	0.001	0.07	41.1
AWS			
0.003	0.001	0.07	40.1

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