SW-2209 Cored

TYPE : Rutile

AWS A5.22 /ASME SFA5.22 E2209T1-1/-4
JIS Z3323 TS2209-FB1
EN ISO 17633-A-T 22 9 3 N L M/C 2

Applications

SW-2209 Cored is an all positional flux cored wire for duplex stainless steels like 2205.

Characteristics on Usage

SW-2209 Cored is a titania type flux cored wire for all position welding with CO_2 & Mixed gas.
As deposition rate is higher than solid wire and MMA electrode highly efficient welding can be performed.

Notes on Usage

① Proper preheating (50~150˚C)(122~302˚F) and interpass temperature must be adopted in order to release hydrogen which may cause crack in weld metal.
② Both 100% CO_2 and mixed (Ar+20~25% CO_2) gas are useful.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB) 3G (PF) 4G (PE)	DC +	CO_2/Ar+20~25%CO_2

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO_2)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.03	0.70	1.10	0.02	0.010	23.5	8.7	3.2	0.10

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO_2)

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)	PREN
680 (98,600)	820 (119,100)	27	-20 (-4) -50 (-58)	60 (44) 40 (30)	36

Pitting Resistance Equivalent (Shieding Gas : 100%CO_2)

PREN = Cr+3.3×Mo+16×N

Approval

BV, DNV

I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.6	Spool(kg)	12.5	15
(in)	.045	1/16	(lbs)	28	33

Ferrite Contents of All Weld Metal (Shielding Gas: 100% CO_2)

	WRC-1992(FN)	Shaeffler Diagram(%)
As welded	53~55	58~59

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.6 (1/16)
F & HF	170~220	240~280
V-up,OH	110~160	-