

## AA 2209

**CATEGORY** FCAW Flux-Cored

**TYPE** Rutile fluxcored wire for welding duplex stainless steels

**APPLICATIONS** Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc.

**PROPERTIES** Smooth drop transfer and stable arc with no spatter losses. High productivity and weldability, better wetting properties compared to solid wires. Ductile weld metal quality and X-ray soundness with easy slag removal and ferrite level between 30 and 50 (FN). Excellent for use in position and down hand welding. Excellent against pitting and stress corrosion.  
PREN above 35 weldmetal offers outstanding resistance against pitting.

**CLASSIFICATION**

AWS	A 5.22: E 2209 T0-1/-4
EN ISO	17633-A: T 22 9 3 N L R M 3 17633-B: TS 2209-FBO
DIN: W.Nr.	1.4462
DIN	8556: 22 9 3 L

**SUITABLE FOR** Welding wrought, forged or cast duplex stainless steels in the as welded condition. Also suitable for dissimilar welding of low alloyed steels and common stainless steels, UNS S31803, S32205, UR 45N & UR 45N+, 2101, 2205, SAF 2205 Fafer 4462, NKCr22, SM22Cr, Falc 223 UNS S32304 : UR 35 N SAF 2304.  
W.Nr: 1.4162, 1.4462, X2CrNiMoN 22 5 3, 1.4362, X2CrNiN 23 4, 1.4463, 1.4460, 1.4583

**APPROVALS** TUV (12421.00), CE approved

**WELDING POSITIONS:**



**TYPICAL DEPOSIT WEIGHT % (M21)**

C	Mn	Si	Cr	Ni	Mo	N	P	S
0.03	1.40	0.80	23	9.5	3.3	0.14	0.02	0.008

**TYPICAL WELD METAL PROPERTIES (M21)**

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			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	630	780	28			>35	

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
1,2	18-35	100-270	D-200 / S-300	5 / 15	1000 / 1080
1.6	22-36	170-320	S-300	15	1080

**REDRYING TEMPERATURE** 150°C / 24hr

**GAS ACC. EN ISO 14175:** M21