

AA 2209 M

CATEGORY	FCAW Flux-Cored																							
TYPE	Metal cored 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 more stable arc compare to solid wires. High productivity and weldability, better wetting properties compared to solid wires. Ductile weld metal quality and X-ray soundness and ferrite level between 30 and 50 (FN). Excellent for use in down hand welding. Excellent against pitting and stress corrosion. The PREN above 35 weldmetal offers outstanding resistance against pitting.																							
CLASSIFICATION	AWS	A 5.9: EC 2209																						
	EN ISO	17633-A: T 22 9 3 N L M M 1 17633-B: TS2209-MG0																						
	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+, 2205, SAF 2205 Fafer 4462, NKCr22, SM22Cr, Falc 223 UNS S32304 : UR 35 N SAF 2304 W.Nr: 1.4462, X2CrNiMoN 22 5 3, 1.4362, X2CrNiN 23 4, 1.4463, 1.4460, 1.4583																							
APPROVALS	CE approved																							
WELDING POSITIONS:																								
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REDRYING TEMPERATURE	150°C / 24hr.																							
GAS ACC. EN ISO 14175:	M12, Z (Ar + Co2 <0,5%He), I1 Ar																							