CEWELD[®]

AA 2209-P

TYPE		Rutile fluxcor	ed wire for v	welding duplex	els					
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 weldabill properties compared to solid wires. Ductile weld metal quality and X-ray soundness with ea and ferrite level between 30 and 50 (FN). Excellent for use in position and down hand weldir against pitting and stress corrosion. The PREN above 35 weldmetal offers outstanding resis pitting.								
CLASSIFICATION		AWS A 5.22: E 2209 T1-4 A 5.22: E 2209 T1-1 EN ISO 17633-A: T 22 9 3 N L P M 1 17633-B: TS 2209-FB0 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 dissim welding of low alloyed steels and common stainless steels, UNS S31803, S32205, UR 45N & UR 45N+, 22 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								
SUITABLE FOR		welding of lov SAF 2205 Fa	walloyed ste fer 4462, Nk	eels and comm (Cr22, SM22Cr	non stainless , Falc 223 UN	steels, UNS S318 S S32304 : UR 3	803, S32205, UR 45N 5 N SAF 2304			
SUITABLE FOR		welding of lov SAF 2205 Fa	w alloyed ste fer 4462, Nk , X2CrNiMol	eels and comm (Cr22, SM22Cr	non stainless , Falc 223 UN	steels, UNS S318 S S32304 : UR 3	803, S32205, UR 45N 5 N SAF 2304			
		welding of lov SAF 2205 Fa W.Nr: 1.4462 CE approved	w alloyed ste fer 4462, Nk , X2CrNiMol	eels and comm (Cr22, SM22Cr N 22 5 3, 1.436	non stainless , Falc 223 UN	steels, UNS S318 S S32304 : UR 3	803, S32205, UR 45N 5 N SAF 2304			
APPROVALS MELDING POSITIO	NS:	welding of lov SAF 2205 Fa W.Nr: 1.4462 CE approved	w alloyed ste fer 4462, Nk , X2CrNiMol	eels and comm (Cr22, SM22Cr N 22 5 3, 1.436	non stainless , Falc 223 UN	steels, UNS S318 S S32304 : UR 3	803, S32205, UR 45N 5 N SAF 2304			
APPROVALS VELDING POSITIO	NS:	welding of lov SAF 2205 Fa W.Nr: 1.4462 CE approved	w alloyed ste fer 4462, Nk , X2CrNiMol	eels and comm (Cr22, SM22Cr N 22 5 3, 1.436	non stainless , Falc 223 UN	steels, UNS S318 S S32304 : UR 3	803, S32205, UR 45N 5 N SAF 2304			
APPROVALS WELDING POSITIO YPICAL DEPOSIT	NS: WEIGHT % (welding of lov SAF 2205 Fa W.Nr: 1.4462 CE approved	w alloyed ste fer 4462, NK , X2CrNiMof	eels and comm (Cr22, SM22Cr N 22 5 3, 1.436	non stainless , Falc 223 UN 52, X2CrNiN 2	steels, UNS S318 S S32304 : UR 3 3 4, 1.4463, 1.44	303, S32205, UR 45N 5 N SAF 2304 460, 1.4583	N & UR 45N+, 220		
APPROVALS MELDING POSITIO TYPICAL DEPOSIT C 0.03	NS: WEIGHT % (<u>Mn</u> 1.4	welding of lov SAF 2205 Fa W.Nr: 1.4462 CE approved UPA M21) Si 0.8	w alloyed ste fer 4462, NK , X2CrNiMof	eels and comm (Cr22, SM22Cr N 22 5 3, 1.436	non stainless , Falc 223 UN 52, X2CrNiN 2	steels, UNS S318 S S32304 : UR 3 3 4, 1.4463, 1.44	903, S32205, UR 45N 5 N SAF 2304 460, 1.4583	N & UR 45N+, 220		
APPROVALS VELDING POSITIO YPICAL DEPOSIT C 0.03	NS: WEIGHT % (<u>Mn</u> 1.4	welding of lov SAF 2205 Fa W.Nr: 1.4462 CE approved UPA M21) Si 0.8 CTIES (M21)	w alloyed ste fer 4462, NK , X2CrNiMof	eels and comm (Cr22, SM22Cr N 22 5 3, 1.436	non stainless , Falc 223 UN 52, X2CrNiN 2	steels, UNS S318 S S32304 : UR 33 3 4, 1.4463, 1.44	B03, S32205, UR 45N 5 N SAF 2304 460, 1.4583	N & UR 45N+, 220 S 0.008		
APPROVALS MELDING POSITIO TYPICAL DEPOSIT C 0.03 TYPICAL WELD ME	NS: WEIGHT % (Mn 1.4 TAL PROPER	welding of lov SAF 2205 Fa W.Nr: 1.4462 CE approved UPA M21) Si 0.8	w alloyed ste fer 4462, NK , X2CrNiMof	eels and comm KCr22, SM22Cr N 22 5 3, 1.436 Ni 9.5	non stainless , Falc 223 UN 52, X2CrNiN 2	steels, UNS S318 S S32304 : UR 3 3 4, 1.4463, 1.44	B03, S32205, UR 45N 5 N SAF 2304 460, 1.4583	N & UR 45N+, 220		

WELDING PARAMETERS / PACKING

	Welding Parameter	ſS	Packing			
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	
1,2	18-33	90-250	D-200 / S-300	5 / 15	1000 / 1080	

REDRYING TEMPERATURE 150°C/24hr

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