

AA 2209-Pi

CATEGORY FCAW Flux-Cored

TYPE Rutile fluxcored wire for welding duplex stainless steels with improved impact properties

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. The PRE typical value of 36.1 stimulates outstanding impact properties at sub zero temperatures.

CLASSIFICATION

AWS	A 5.22: E 2209 T1-1/4
EN ISO	17633-A: T 22 9 3 N L P C /M1 17633-A: 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 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:



TYPICAL DEPOSIT WEIGHT % (M21)

C	Mn	Si	Cr	Ni	Mo	N	P	S
0.03	0.82	0.54	22.49	9.35	3.43	0.15	0.015	0.003

TYPICAL WELD METAL PROPERTIES (M21)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				0°C	-40°C	-60°C	
AW	612	815	29	~78		~62	

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 / D-300	5 / 15	1000 / 1080

REDRYING TEMPERATURE 150°C / 24hr