

SA 2209

CATEGORY SAW Arc Submerged

TYPE Stainless steel Duplex filler metal for submerged arc welding

APPLICATIONS Boilers, tanks, vessels and similar objects that needs high strength and improved resistance against intergranular corrosion, pitting and stress corrosion.

PROPERTIES SA 2209 has high general corrosion resistance in media containing chloride and hydrogen sulfide. Combined with our fused flux **FL 880** excellent results are obtained for both joining and cladding applications with self lifting slag and it leaves a fine rippled surface free from slag residues or pin holes.

CLASSIFICATION

AWS	A 5.9: ER 2209
EN ISO	14343-A: S 22 9 3 N L
DIN: W.Nr.	1.4462

SUITABLE FOR 1.4462, 1.4463, 1.4460, 1.4583, P235GH, P265GH, S255N, P295GH, S355N, 16Mo3.

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL VALUES FOR WELD METAL WITH FL 880 FLUX

C	Mn	Si	Cr	Ni	Mo	N
<0.03	<2.0	<0.9	21.5-23.5	7.5-9.5	2.5-3.5	0.08-0.20

MECHANICAL PROPERTIES WITH FL 880

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW	>550	>750	>25	>80		>40	

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Spool type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
1.6	27-30	200-300	K-415	25	1000
2.4	29-33	300-400	K-415	25	1000
3.2	29-33	350-500	K-415	25	1000
4.0	30-36	400-600	K-415	25	1000

REDRYING TEMPERATURE not required