

AA 2101 Lean Duplex

CATEGORY	FCAW Flux-Cored																											
TYPE	Rutile fluxcored wire for welding lean duplex stainless steel																											
APPLICATIONS	Very well suited for the chemical industries (e.g. bio fuel), the pulp and paper industry and also the food industry.																											
PROPERTIES	AA 2101 has excellent welding properties and was developed especially for the steel grade 1.4162/UNS S 32101. Due to the higher Mn and N - content of the Lean duplex base material, the slag viscosity and therefore the flow behaviour is changing and the welding bead is liquid for a longer time. The result is a very smooth seam.																											
CLASSIFICATION	AWS	A 5.22: E2209 T0-G																										
	EN ISO	17633: T Z 24 9 N L R M(C) 3																										
	DIN: W.Nr.	1.4162																										
	DIN	8556: ~ 24 9 N L																										
SUITABLE FOR	Lean duplex stainless steel EN 1.4162 / ASTM 32101 grade such as LDX2101® (Avesta)																											
APPROVALS	CE approved																											
WELDING POSITIONS:																												
WELD DEPOSIT WEIGHT % (M21)	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>N</th> <th>P</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.025</td> <td>1.45</td> <td>0.65</td> <td>24.5</td> <td>8.4</td> <td>0.13</td> <td>0.017</td> <td>0.003</td> </tr> </tbody> </table>							C	Mn	Si	Cr	Ni	N	P	S	0.025	1.45	0.65	24.5	8.4	0.13	0.017	0.003					
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REDRYING TEMPERATURE	150°C / 24hr																											
PROTECTIVE GAS	Co2 / Argon-Co2																											