

## 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
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APPROVALS	CE approved
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### 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 <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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
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