



FCW 2209P

*All position duplex
Flux cored wire*

Classification

AWS A5.22 : E2209T1-1/-4

ISO 17633-A : T 22 9 3 N L P M21(C1) 1

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc welding in all positions of duplex steels such as Uranus 45N*, 2205, 2304. Resistant to severe corrosive environments (inter crystalline attack, pitting corrosion, crevice, and stress corrosion). Wire with rutile fast freezing to weld in all positions.

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Main applications: For pumps, vessels, piping systems etc. attacked by chloride containing solutions. But also for impellers and other components which require high strength combined with corrosion attack.

Base materials:

UNS	Alloy	EN 10088	Material N°	CLI
S31803		X2CrNiMoN22-5-3	1.4462	URANUS 45N
S32304	35N	X2CrNi23-4	1.4362	URANUS 35N
S32900	329	X3CrNiMoN27-5-2	1.4460	

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S	N ₂
Min			0.5	21.0	7.5	2.5				0.08
Max	0.04	1.0	2.0	24.0	10.0	4.0	0.5	0.030	0.025	0.20
Type	0.03	0.80	1.1	23.0	9.0	3.1	0.10	0.020	0.008	0.15

PREN : >35

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	450	690	20	
Max				
Type	630	780	28	-60°C 35

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	130 - 270	22 - 35	12 - 25	ISO 14175 : M21 (Ar/CO ₂) 10 - 20 l/min



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