



UP 2209

Classification

AWS A5.9 : ER2209

ISO 14343-A : S 22 9 3 N L

Description & Applications

Low carbon content solid wire for submerged arc welding of Duplex (austenitic-ferritic microstructure) type stainless steels like Ur 35N™ or 45N™*. Resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion. Used for components which require high strength combined with corrosion attack. Could be used with service temperature up to +250°C.

* Trade mark of CREUSOT LOIRE

Main applications: For pumps, vessels, piping systems.

Base materials:

Austenitic-ferritic stainless steels

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

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co	N
Min			0.50	21.5	7.5	2.5						0.10
Max	0.03	0.90	2.00	23.5	9.5	3.5	0.5	-	0.03	0.02	-	0.20
Type	0.012	0.40	1.5	23.1	8.7	3.2	0.10	0.01	0.015	0.005	0.05	0.14

PREN >35

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW = +	2.4	340 - 380	28 - 29	18	48 - 60	UP WP380M
	3.2	360 - 430	28 - 29	20	48 - 60	UP INOX L
	4.0	450 - 550	28 - 30	22	50 - 60	UP INOX 620

FT En-SN01-181005

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr