



CEWELD AA 2209Pi

TYPE	Rutile fluxcored wire for welding duplex stainless steels with improved impact properties. (Type 2209, 1.4462)									
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: E2209T1-4								
	EN ISO	17633-A: T 22 9 3 N L P M21 2								
	W.Nr.	1.4462								
	F-nr	6								
	FM	5								
SUITABLE FOR	ISO 15608: 10.1-10.2 Austenitic > 24 % Cr ≤ 4% Ni, DUPLEX 2209, 22%Cr 9%Ni 3%Mo 1.4417, 1.4462, 1.4362, 1.4162, 1.4463, 1.4460, 1.4583 X 2 CrNiMoSi 19 5, X 2 CrNiN 23 4, X 2 CrNiMoN 22 5 3, X10CrNiMoNb18-12 316LN, 318LN UNS S31803, S32205, S32304 SAF 2205 Fafer 4462, NKCr22, SM22Cr, Falc 223 UR 45N & UR 45N+, 2101, 2205, UR 35 N SAF 2304 mix 1.4462 X2CrNiMoN22-5-3 mit P235GH/ P265GH, S255N, P295GH, S355N, 16Mo3									
APPROVALS	CE									
WELDING POSITIONS										
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	N	PREN
	0.03	0.55	0.85	0.015	0.003	22.5	9.5	3.5	0.15	36
MECHANICAL PROPERTIES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness			
					0°C	-60°C				
	As Welded	612	815	29	80	65	HRc			
REDRYING	140°C / 24 hr									
GAS ACC. EN ISO 14175	M21									