



CEWELD AA 2209Pi

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

PROPRIÉTÉS 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

CONVIENT POUR ISO 15608: 10.1-10.2 Austenitic $> 24 \% \text{Cr} \leq 4 \% \text{Ni}$, 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

AGRÉMENTS CE

POSITIONS DE SOUDAGE



**ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)**

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

PROPRIÉTÉS MÉCANIQUES

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

ETUVAGE 140°C / 24 hr

GAS ACC. EN ISO 14175 M21