



# CEWELD AA 2209P

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                               |                      |                    |                         |      |       |     |          |     |
|---------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|----------------------|--------------------|-------------------------|------|-------|-----|----------|-----|
| TYPE                                        | Rutile fluxcored wire for welding duplex stainless steels. (Type E2209, T 22 9 3 N L P)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                               |                      |                    |                         |      |       |     |          |     |
| APPLICATIONS                                | CEWELD AA 2209P is designed for welding 22Cr duplex stainless steels in offshore and shipbuilding, for chemical tankers, in the chemical/petrochemical industry, in the pulp and paper industry, 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 PREN above 35 weldmetal offers outstanding resistance against pitting.                                                                                                                                                                |                               |                      |                    |                         |      |       |     |          |     |
| 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<br>1.4417, 1.4462, 1.4362, 1.4162, 1.4463, 1.4460, 1.4583<br>X 2 CrNiMoSi 19 5, X 2 CrNiN 23 4, X 2 CrNiMoN 22 5 3, X10CrNiMoNb18-12<br>316LN, 318LN<br>UNS S31803, S32205, S32304<br>SAF 2205 Fafer 4462, NKCr22, SM22Cr, Falc 223 UR 45N & UR 45N+, 2101, 2205, UR 35 N SAF 2304<br>mix 1.4462 X2CrNiMoN22-5-3 mit P235GH/ P265GH, S255N, P295GH, S355N, 16Mo3                                                                                                                                                                 |                               |                      |                    |                         |      |       |     |          |     |
| APPROVALS                                   | CE, Lloyds: LR23315606WC, DNV: TAW00005FD                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                               |                      |                    |                         |      |       |     |          |     |
| WELDING POSITIONS                           | <div></div> |                               |                      |                    |                         |      |       |     |          |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Si                            | Mn                   | P                  | S                       | Cr   | Ni    | Mo  | N        | FNW |
|                                             | 0.03                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 0.5                           | 1.1                  | 0.01               | 0.009                   | 23.1 | 8.9   | 3.6 | 0.11     | 49  |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | R <sub>p0,2</sub> (MPa)       | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |      |       |     | Hardness |     |
|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                               |                      |                    |                         |      |       |     |          |     |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 650                           | 825                  | 28                 | -40°C                   |      | -60°C |     | HRC      |     |
| REDRYING                                    | 140°C / 24 hr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                               |                      |                    |                         |      |       |     |          |     |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                               |                      |                    |                         |      |       |     |          |     |



# CEWELD AA 2209P

AA 2209P 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663414748 |
| D-200     | 5       | 8720663414762 |
| D-270     | 15      | 8720663424648 |