



CEWELD AA 2209

TYPE	Rutile fluxcored wire for welding duplex stainless steels. (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.PREN above 35 weldmetal offers outstanding resistance against pitting.							
CLASSIFICATION	AWS	A 5.22: E2209T0-4						
	EN ISO	17633-A: T 22 9 3 N L R M21 3						
	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	 PA  PB  PC							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	Cr	Ni	Mo	N
	0.03	0.8	1.4	0.02	23	9.5	3.3	0.14
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					-60°C			
	As Welded	630	780	30	40		HRc	
REDRYING	140°C / 24 hr							
GAS ACC. EN ISO 14175	M21							



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AA 2209 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414731
D-200	5	8720663414755