



# 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	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E2209T1-4</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 22 9 3 N L P M21 2</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4462</td> </tr> </table>	AWS	A 5.22: E2209T1-4	EN ISO	17633-A: T 22 9 3 N L P M21 2	F-nr	6	FM	5	W.Nr.	1.4462										
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SUITABLE FOR	<p><b>ISO 15608: 10.1-10.2 Austenitic &gt; 24 % Cr ≤ 4% Ni, DUPLEX 2209, 22%Cr 9%Ni 3%Mo</b>            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 &amp; UR 45N+, 2101, 2205, UR 35 N SAF 2304            mix 1.4462 X2CrNiMoN22-5-3 mit P235GH/ P265GH, S255N, P295GH, S355N, 16Mo3</p>																				
APPROVALS	CE Lloyds (LR23315606WC) DNV (TAW00005FD)																				
WELDING POSITIONS																					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> <th>FNW</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.5</td> <td>1.1</td> <td>0.01</td> <td>0.009</td> <td>23.1</td> <td>8.9</td> <td>3.6</td> <td>0.11</td> <td>49</td> </tr> </tbody> </table>	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
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>p0,2</sub> MPa</th> <th rowspan="2">R<sub>m</sub> MPa</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>650</td> <td>825</td> <td>28</td> <td>42</td> <td>35</td> </tr> </tbody> </table>	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		-40°C	-60°C	As Welded /	650	825	28	42	35						
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REDRYING TEMPERATURE	140°C / 24 hr																				
GAS ACCORDING EN 14175	M21																				



# CEWELD AA 2209P

AA 2209P 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663414748
D-200	5	8720663414762
D-270	15	8720663424648