




# CEWELD AA 2101 (Lean Duplex)

<b>TYPE</b>	Rutile fluxcored wire for welding lean duplex stainless steel								
<b>ANWENDUNGEN</b>	Very well suited for the chemical industries (e.g. bio fuel), the pulp and paper industry and also the food industry.								
<b>EIGENSCHAFTEN</b>	AA 2101 has excellent welding properties and was developed especially for the steel grade 1.4162/UNS S 32101. Due to the higher Mn and N – content of the Lean duplex base material, the slag viscosity and therefore the flow behaviour is changing and the welding bead is liquid for a longer time. The result is a very smooth seam.								
<b>KLASSIFIKATION</b>	AWS	A 5.22: E2307T1-1							
	EN ISO	17633-A: T 23 7 N L P M21 2							
	W.Nr.	1.4162							
	F-nr	6							
	FM	5							
<b>GEEIGNET FÜR</b>	1.4162, 1.4362, 1.4482, 1.4062 X2CrMnNiN21-5-1, X2CrMnNiN22-5-2, X2CrMnNi 22-5-2, X2CrNiN23-4, X2CrMnNiMoN21-5-3, X2CrNiN23-4 UNS S32101, S32001, S32304, LEAN DUPLEX UNS S32304, LEAN DUPLEX UNS S32001, SAF 2304, 2001 ASME SA 240, ASME SA 790, Case 2418 LDX2101® (Avesta), Valbruna V234N, SS LD24								
<b>ZULASSUNGEN</b>	CE								
<b>SCHWEISSPOSITIONEN</b>									
<b>TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)</b>	C	Si	Mn	P	S	Cr	Ni	Mo	N
	0.03	0.45	1.25	0.02	0.003	24.5	8	0.2	0.15
<b>MECHANISCHE GÜTEWERTE</b>	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	571	750	29	-40°C			HRc	
<b>RÜCKTROCKNUNG</b>	140°C / 24 hr								
<b>GAS ACC. EN ISO 14175</b>	M21								