CEWELD AA 2209P

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile fluxcored wire for welding duplex stainless steels

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 weldabillity, 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

CONVIENT POUR

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

AGRÉMENTS

CE, Lloyds: LR23315606WC, DNV: TAW00005FD

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	650	825	28	42	35	HRc

ETUVAGE

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