



# CEWELD AA 2209M

**TYPE** Metal cored 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 more stable arc compare to solid wires. High productivity and weldability, better wetting properties compared to solid wires. Ductile weld metal quality and X-ray soundness and ferrite level between 30 and 50 (FN). Excellent for use in down hand welding. Excellent against pitting and stress corrosion. The PREN above 35 weldmetal offers outstanding resistance against pitting.

**CLASSIFICATION**

|        |                               |
|--------|-------------------------------|
| AWS    | A 5.22: EC2209                |
| EN ISO | 17633-A: T 22 9 3 N L M M21 1 |
| 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**

**POSITIONS DE SOUDAGE**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

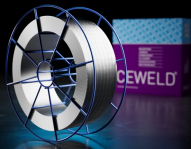
| C    | Si  | Mn  | P    | Cr | Ni  | Mo | N   | S     |
|------|-----|-----|------|----|-----|----|-----|-------|
| 0.03 | 0.6 | 1.4 | 0.02 | 23 | 8.5 | 3  | 1.4 | 0.015 |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |  | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
|                |                         |                      |                    | -60°C                   |  |          |
| As Welded      | 500                     | 750                  | 26                 | 35                      |  | HRc      |

**ETUVAGE** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21



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AA 2209M 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663414779 |