COREFIL 2209P

Flux cored wires [FCAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 17633-A : T 22 9 3 N L R C1(M21) 2 DIN 8556 : 22 9 3 L AWS A-5.22 : E 2209T1-1/4 W.Nr. : 1.4462		Constructions & Engineering Steel construction yards Petrochemical and chemical industry Shipbuilding&Offshore

- Flux cored wire for welding 2205 duplex and lean duplex steels in all positions.
- Very stable arc.
- Very good weld appearance.
- Easy or self-removing slag.
- High resistance to pitting and stress corrosion cracking.
- High yield strength.
- Good resistance to stress corrosion cracking in fluids containing chlorides (e.g. seawater).
- The weld metal contains approx. 30% feerite and 70% austenite.
- Low fume generation compared to solid wires.

Base material

EN	W.Nr.	AISI/UNS/another
X2CrNiMoN 22-5-3	1.4462	2205 / S31803, S32205
X2CrNiMoSi19 5	1.4417	301LN / S31500
X3CrNiMoN 27 5 2	1.4460	329 / S32900
X2CrNiN 23 4	1.4362	S32304 / S32304
		S32404
For dissimilar connections between non-alloy and low-alloy steels to duplex steels		
1.4462 X2CrNiMoN 22 5 3 with 1.4583 X10CrNiMoNb 18 12		
1.4462 X2CrNiMoN 22 5 3 z P235GH, P265GH, S255N, P295GH, S430N, 16Mo3, UNS S31803, S322005		
		/J92205
		//UR45N, UR45N+/UR35N
		//NK Cr22 (Nippon Kokan)
X10CrniMoNb10 12	1.4162	S32101
X4CrniMoN27 5 2	1.4460	329 / S32900
X10CrniMoNb10 12	1.4583	318
G-X8 CrNi26 7	1.4347	
X4 CrNiMoNb25 7	1.4582	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	N
<0,03	0,60	0,60	22,60	9,00	3,00	0,13

Typical mechanical properties

Yield strength Re [N/mm2]	> 450 (typ. 680)
Tensile strength Rm [N/mm2]	> 550 (typ. 790)

Elongation A5 [%]	> 20 (typ. 26)
Impact energy Kv [J]	65 J (0°C) /
Wire/rod type	flux cored
Flux type	rutile
Ferrite content	45
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

ø	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	150 - 300	24 - 33	20 - 25	15,0
1,6	200 - 400	24 - 35	20 - 25	15,0

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