

# TETRA V 22 9 3L-G

## Duplex won't leave you perplexed!

This rutile flux cored stainless steel wire - type 2209 - will surpass your expectations for joining and cladding jobs.

Ideal for out of position jobs, the weld deposit provides **outstanding mechanical properties**.



## Features

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 22% chromium - 9% nickel - 3% molybdenum - nitrogen - low carbon duplex stainless steel deposit
- Welded with classical economical Ar-CO<sub>2</sub> (EN ISO 14175: M21)
- TUV approval

## Benefits

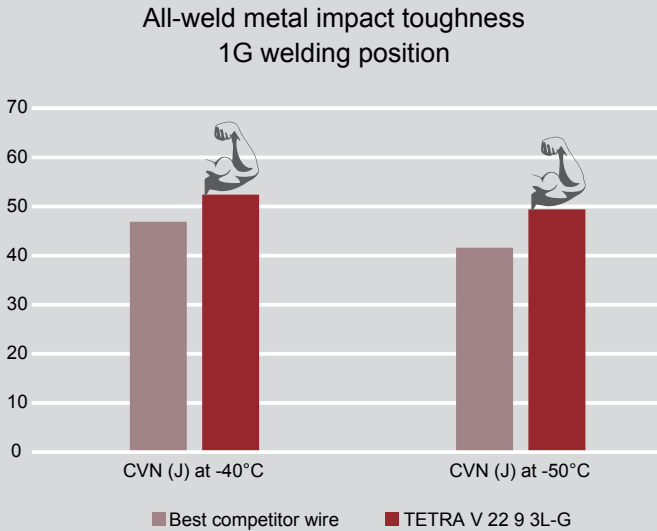
- Easy to use thanks to the slag properties
  - *Fast freezing slag*
  - *Outstanding slag release*
- Excellent weldability
- Less Hexavalent Cr (%Cr VI)
- Outstanding mechanical properties (especially impact toughness)
- CPT  $\geq 25^{\circ}\text{C}$



# All-weld metal mechanical properties

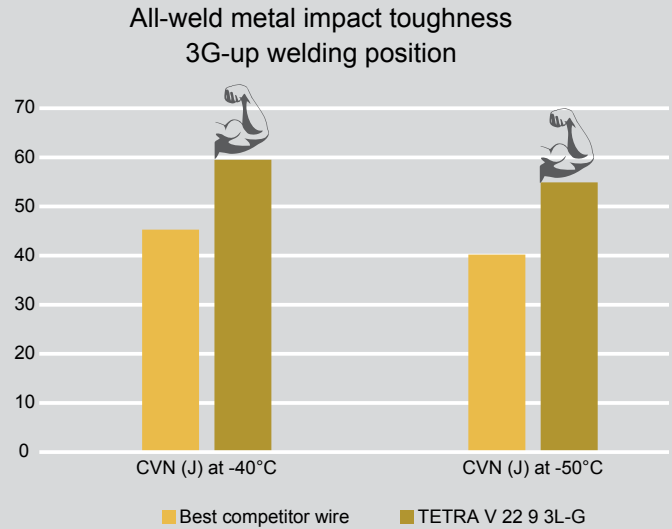
## 1G welding position:

DC+, 180-200 A, 29 V, 1.0-1.2 kJ/mm



## 3G-up welding position:

DC+, 140-150 A, 23-24 V, 1.7-2.7 kJ/mm



## Some tips about Duplex stainless steels!



The Helix Bridge, Singapore - made of duplex stainless steel

Duplex stainless steels have a two-phase microstructure (austenite and ferrite). Due to their high content of chromium, molybdenum and nitrogen, they have excellent resistance to pitting and crevice corrosion.



TETRA V 22 9 3L-G weld metal solidifies with a fully ferritic structure. Austenite appears during the cooling phase. The final microstructure consists of austenite + ferrite (35-65 FN)



- Preheat is generally not required
- Interpass temperature should be below 150°C
- Heat input should be kept between 1.0 to 2.5 kJ/mm

