Technical data sheet 011121MBA	Cored welding wire # WA TUB SS 2209	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E2209T1-4 - E2209T1-1
EN ISO 17633-A:	T 22 9 3 N L P M21 1 - T 22 9 3 N L P C1 1
EN ISO 17633-B:	TS2209-F M21 1 – TS2209-F C1 1
UNS Number:	W39239
Equivalent Material Number:	1.4462
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 22% chromium - 9% nickel - 3% molybdenum - nitrogen - low carbon duplex stainless steel deposit
- Specifically designed for out-of-position welding
- Good slag detachment, attractive bead appearance and very good penetration
- Excellent X-ray soundness
- Maximum productivity for completion of vertical welds
- Welded with classical economical Ar-CO_2 mixtures or CO_2

APPLICATIONS

Welding wrought, forged or cast duplex stainless steels for service in the as-welded condition
Heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels

Examples:

UNS	Material number	EN Symbol
S31803	1.4462	X2CrNiMoN 22-5-3
S32205	1.4462	
S32304	1.4362	X2CrNiN 23 4

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	N
0.03	0.9	0.5	23	9	3.1	0.13

Typical ferrite level: 40 FN
PRE_N = Cr + 3.3 Mo + 16 N ≥ 35

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]	CVN [J]
690	450	20	-40°C : 47	-60°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]	CVN [J]
820	630	27	-40°C : 60	-60°C: 40

SHIELDING GAS

M21 (Ar + 15 - 25% CO_2), M20 (Ar + 5 - 15% CO_2) gas mixtures or C1 (CO_2) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	130 - 270	22 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.2 mm	
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M	
	S200	BS300
Weight	5 kg	15 kg

Other packaging and other diameters: please consult us