



CEWELD AA 2209M

TYPE	Metal cored wire for welding duplex stainless steels								
ANWENDUNGEN	Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc..								
EIGENSCHAFTEN	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.								
KLASSIFIKATION	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							
GEEIGNET FÜR	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								
ZULASSUNGEN									
SCHWEISSPOSITIONEN	  								
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	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
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness	
					-60°C				
	As Welded	500	750	26	35			HRc	
RÜCKTROCKNUNG	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