CEWELD AA 2209M

certilas® THE FILLER METAL SPECIALIST

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 weldabillity, 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

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

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -60°C	Hardness
As Welded	500	750	26	35	HRc

RÜCKTROCKNUNG

140°C / 24 hr

GAS ACC. EN ISO 14175

M21

CEWELD AA 2209M

AA 2209M 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414779