



# CEWELD SA 2209

**TYPE** Stainless steel Duplex filler metal for submerged arc welding. (Type 2209, 1.4462)

**APPLICATIONS** Boilers, tanks, vessels and similar objects that needs high strength and improved resistance against intergranular corrosion, pitting and stress corrosion.

**PROPERTIES** SA 2209 has high general corrosion resistance in media containing chloride and hydrogen sulfide. Combined with our fused flux FL 880 excellent results are obtained for both joining and cladding applications with self lifting slag and it leaves a fine rippled surface free from slag residues or pin holes. Also our agglomerated flux FL 838 can be used.

**CLASSIFICATION**

AWS	A 5.9: ER2209
EN ISO	14343-A: S 22 9 3 N L
W.Nr.	1.4462
F-nr	5
FM	6

**SUITABLE FOR**

**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

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.02	0.8	1.5	0.02	0.02	22	9	3	0.15

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	-60°C	
As Welded	570	780	25	80	40	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175**



# CEWELD SA 2209

SA 2209 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663414601

SA 2209 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663414243