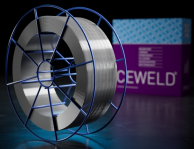


# CEWELD 2209 Duplex

| TYPE  | Massieve lasdraad voor het lassen van Duplex roestvaststaal.  |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
|---|---|----------------|-------------------------|----------------------|-----------------------|-------------------------|--------------------|----------|-------------------------|-------|-----------|-----|-----|----|------|----|-----|
| TOEPASSINGEN                                      | Gebruikt voor pijpverbindingen en algemene fabricage in de offshore, olie- en gasindustrie en chemische procesindustrie. Ook geschikt voor het bekleden van staal om corrosiebestendige lagen te verkrijgen.  |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| EIGENSCHAPPEN                                     | CEWELD 2209 Duplex is een massieve, corrosiebestendige duplexdraad voor het lassen van austenitisch-ferritische roestvaste legeringen van de types 22% Cr, 5% Ni, 3% Mo en heeft een hoge algemene corrosiebestendigheid. In chloride- en waterstofsulfidehoudende media heeft de legering een hoge weerstand tegen interkristallijne corrosie, putcorrosie en vooral tegen spanningscorrosie.  |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| CLASSIFICATIE                                     | <table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER2209</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 22 9 3 N L</td> </tr> <tr> <td>W.Nr.</td> <td>1.4462</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>  | AWS            | A 5.9: ER2209           | EN ISO               | 14343-A: G 22 9 3 N L | W.Nr.                   | 1.4462             | F-nr     | 6                       | FM    | 5         |     |     |    |      |    |     |
| AWS   | A 5.9: ER2209   |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| EN ISO  | 14343-A: G 22 9 3 N L   |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| W.Nr.   | 1.4462  |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| F-nr  | 6   |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| FM  | 5   |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| GESCHIKT VOOR                                     | <p><b>ISO 15608: 10.1-10.2 Austenitic &gt; 24 % Cr ≤ 4% Ni, DUPLEX 2209, 22%Cr 9%Ni 3%Mo</b><br/>           1.4417, 1.4462, 1.4362, 1.4162, 1.4463, 1.4460, 1.4583<br/>           X 2 CrNiMoSi 19 5, X 2 CrNiN 23 4, X 2 CrNiMoN 22 5 3, X10CrNiMoNb18-12<br/>           316LN, 318LN<br/>           UNS S31803, S32205, S32304<br/>           SAF 2205 Fafer 4462, NKCr22, SM22Cr, Falc 223 UR 45N &amp; UR 45N+, 2101, 2205, UR 35 N SAF 2304<br/>           mix 1.4462 X2CrNiMoN22-5-3 mit P235GH/ P265GH, S255N, P295GH, S355N, 16Mo3</p> |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| GOEDKEURINGEN                                     | TÜV: 12397.00, CE   |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| LASPOSITIES                                       |   |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.5</td> <td>1.6</td> <td>23</td> <td>9</td> <td>3</td> <td>0.14</td> </tr> </tbody> </table>   | C              | Si                      | Mn                   | Cr                    | Ni                      | Mo                 | N        | 0.02                    | 0.5   | 1.6       | 23  | 9   | 3  | 0.14 |    |     |
| C   | Si  | Mn             | Cr                      | Ni                   | Mo                    | N                       |                    |          |                         |       |           |     |     |    |      |    |     |
| 0.02  | 0.5   | 1.6            | 23                      | 9                    | 3                     | 0.14                    |                    |          |                         |       |           |     |     |    |      |    |     |
| MECHANISCHE WAARDEN                               | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>625</td> <td>780</td> <td>26</td> <td>130</td> <td>85</td> <td>HRc</td> </tr> </tbody> </table>   | 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 | 625 | 780 | 26 | 130  | 85 | HRc |
| 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   | 625   | 780            | 26                      | 130                  | 85                    | HRc                     |                    |          |                         |       |           |     |     |    |      |    |     |
| HERDROGEN   | Not required  |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |
| GAS ACC. EN ISO 14175                             | M13, M12  |                |                         |                      |                       |                         |                    |          |                         |       |           |     |     |    |      |    |     |



# CEWELD 2209 Duplex

## 2209 DUPLEX 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663414496 |
| D-100     | 1       | 8720663414489 |

## 2209 DUPLEX 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663414502 |
| D-100     | 1       | 8720663414519 |

## 2209 DUPLEX 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663414526 |
| D-200     | 5       | 8720663414533 |