

Material Type							
S31803	S322205	1.4462	X2CrNiMoN22-5-3				
Characteristics							
<p>WAAM solid wire of 22 5 3 N L / ER2209 type designed for 3Dprinting of thinner structures with restricted cooling conditions.</p> <p>Provides a ferritic-austenitic weld metal. The resulting microstructure is austenite with 45 – 55% ferrite. The printed structures have very good resistance to pitting and stress corrosion cracking in chloride containing environments after post weld solution annealing.</p>							
Typical analysis of the solid wire (wt.-%)							
	C	Si	Mn	Cr	Ni	Mo	N
wt.-%	0.025	0.5	1.3	22.0	5.0	3.0	0.14
Available products							
<p>Diameter: 1,0 mm – 1,2 mm</p> <p>Package: BS300 15 kg – ECOdrum 100 – ECOdrum 250 – S760 300</p> <p>Other diameters and packages on request.</p>							
Typical mechanical properties acc.to EN ISO 15792-1							
Heat treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation (L ₀ =5d ₀)	Impact energy ISO-V KV J			
	MPa	MPa	%	+20 °C	-40 °C		
u	660	830	28	73	≥ 32		
u	untreated, shielding gas Ar + 20 % He + 2 % CO ₂ , DC+						