



# FCW 2209

High productivity Duplex  
Flux cored wire

## Classification

AWS A5.22 : E2209T0-1/-4

ISO 17633-A : T 22 9 3 N L R M21(C1) 3

## Description & Applications

Flux cored wire for gas shielded (Ar + CO<sub>2</sub>) arc welding in flat and down hand positions of duplex steels such as Uranus 45N\*, 2205, 2304. Resistant to severe corrosive environments (inter crystalline attack, pitting corrosion, crevice, and stress corrosion). High productivity in flat positions and horizontal fillet weld due to easily removal slag.

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**Main applications:** For pumps, vessels, piping systems etc. attacked by chloride containing solutions. But also for impellers and other components which require high strength combined with corrosion attack.

### Base materials:

UNS	Alloy	EN 10088	Material N°	CLI
S31803		X2CrNiMoN22-5-3	1.4462	URANUS 45N
S32304	35N	X2CrNi23-4	1.4362	URANUS 35N
S32900	329	X3CrNiMoN27-5-2	1.4460	

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	N <sub>2</sub>	P	S	Fe
0.03	0.80	1.3	23.0	9.1	3.2	0.10	0.16	0.02	0.008	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	PREN
650	830	28	-20°C 40	> 35

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	

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[www.fsh-welding.com](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)

