



FCW 2209B Flux Cored Wire

Classification

AWS A5-22 : E2209T0-4
EN ISO 17633-A : T22 9 3 N L Z M3

Material N° : 1.4462

Characteristics

Basic flux cored wire to weld with shielding gas protection with an austenitic - ferritic microstructure (Duplex). Special slag system to guaranty an excellent weld metal quality with good impact toughness levels at low temperatures.

Applications

For butt welding and cladding of steels and castings with an austenitic - ferritic structure, which are used 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	Material N°	CLI
S 31803		X2CrNiMoN22-5-3	1.4462	URANUS 45N
S 32304	35 N	X2CrNi23-4	1.4362	
S 32900	329	X3CrNiMoN27-5-2	1.4460	
		G-X8CrNiN26-7	1.4347	
		G-X6CrNiMo24-8-2	1.4463	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	N	P	S	Fe
0.03	0.40	0.90	23.20	9.40	3.30	0.18	0.020	0.008	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (kv)	
	R _m (MPa)	R _{p0.2} (MPa)	A ₅	Temp. °C	J
AW	830	650	28	- 60	45

Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shielding Gas ISO 14175
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	140 - 240	25 - 30	15 - 20	M21 (Ar + 10 - 20 %CO ₂) 18 - 20 l/min

Welding Positions : 1G/PA ; 2G/PC ; 1F ; 2F/PB

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.