

SpecMet CSF-2209P • CSF-2209

AWS A5.22 E2209T1-1 • E2209T0-4 • E2209T0-1

Applications

SPECMET 2209 is suitable for welding wrought, forged or cast duplex stainless steels for service in the as welded condition. Heterogeneous welding between duplex stainless steels and other stainless and low alloyed steels.

Characteristics

1. Rutile flux cored stainless steel wire for gas shielded welding
2. 22% chromium – 9% nickel – 3% moly – low carbon deposit
3. Attractive bead appearance, very good penetration and high productivity
4. Excellent x-ray soundness
5. Maximum performances in the horizontal and downhand positions
6. Can be used out of position
7. Welded with classical economical Ar-CO₂ mixtures or CO₂

Typical Chemical Composition of Weld Metal (%)

C	Mo	Si	Cr	Ni	N	S	P
0.03	3.3	0.8	23	9.5	0.14	0.008	0.020

Typical Mechanical Properties of Weld Metal (%)

Tensile (Mpa)	A%	KCV(J)
790	28	35 @ -50°C

Shielding Gas

M21 gas mixtures (Ar + 5 - 25% CO₂) or C1 (CO₂) according to EN439

Operating Conditions

Diameter (mm)	Current Type	Intensity (A)	Voltage (V)	Stick-out (mm)	Gas flow
1.2	DC (+)	100-270	18-35	12-25	10-20 l/min.
1.6	DC (+)	150-400	22-37	12-25	10-20 l/min.

Packaging

Diameter	1.2mm	1.6mm
Weight	15kg	15kg

Positions: ASME IX: 1G, 1F, 2G, 2F, (3G, 3F, 4F, 4G)