

STRONG FCAW E2209

CLASSIFICATION: AWS SFA 5.22 E2209T1-1/4

STAINLESS STEEL FLUX CORED ARC WELDING WIRE



CHARACTERISTICS

STRONG FCAW E2209 is an all-position, rutile based gas shielded duplex stainless steel flux-cored wire designed for welding of 22Cr/8.5Ni/3Mo/N alloy requiring Austenitic-ferritic type weld deposit. This wire has a smooth-running arc that deposits a very high tensile strength, with very good resistance to stress, corrosion, cracking and pitting. Other key features include Stable arc, low spatter, easy slag removal and radiographic quality welds.

APPLICATIONS

STRONG FCAW E2209 is designed for welding of 2205, 2209 type duplex stainless steels and similar composition. Used for pipe work and general fabrication in the offshore oil, gas and chemical process industries. STRONG FCAW E2209 may also be a good choice when welding Duplex stainless steel such as 2553 to carbon steels or other grades of stainless steels.

TYPICAL WELD METAL CHEMISTRY (%)

C	Mn	Si	N	Cu	Cr	Ni	Mo
0.04 MAX	0.50- 2.00	1.00 MAX	0.08- 0.20	0.50 MAX	21.0- 24.0	7.50- 10.0	2.50- 4.00

ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.22	Y.S. MPa	U.T.S. MPa	ELONGATION %
Typical Results As Welded	655	825	26

PACKAGING SPECIFICATIONS - FCAW

DIA SIZE 1.20MM / 1.60MM

SPOOL WEIGHT 12.5KGS