

❖ Product Description

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| I. Gas shielded, extra low carbon, duplex rutile type FCW wire | IV. Uniform and fine ripples |
| II. Low fumes, very less spatter | V. Typical 22Cr-8.5Ni-3Mo-N alloy weld deposit |
| III. Excellent combination of high strength and resistance to chloride induced SCC and pitting | VI. Austenitic ferritic type weld deposit |
| | VII. Radiographic weld quality |

❖ Range of Application

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| I. Extremely good for welding of Welding of 2205, 2209type duplex stainless steels and similar composition | II. Caste pumps, valve bodies, seawater handling equipment |
| | III. Cladding on carbon and low alloy steels |

❖ Classification

- AWS/SFA 5.22 E2209 T1

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Mo	Cr	Ni	N	Cu
E2209 T1	Min	-	0.50	-	-	-	2.5	21.0	7.5	0.08	-
	Max	0.04	2.00	1.0	0.03	0.04	4.0	24.0	10.0	0.20	0.75

❖ Mechanical Properties of all weld metalss

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
PWHT	690	-	20	-

❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 18-25lit/min

❖ Packaging

- Standard packaging in 15kg Spool form

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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