



MIGINOX FC 2209

FCAW STAINLESS STEEL

AWS A/SFA 5.22 **E2209T1-1/4**

CLASSIFICATION:

EN ISO 17633-A

T 22 9 3 N L P C1 2

T 22 9 3 N L P M21 2

KEY FEATURES:

- Rutile based gas shielded duplex stainless steel FCAW wire
- Typical 22Cr/8.5Ni/3Mo/N alloy
- Austenitic-ferritic type weld deposit
- Stable arc, low spatter and easy slag removal
- Uniform and fine ripples
- Excellent combination of high strength and resistance to chloride induced SCC and pitting
- Radiographic weld quality

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 2205, 2209 type duplex stainless steels and similar composition
- Pipelines transporting chloride bearing products and sour gases
- Cast pumps, Valve bodies and seawater handling equipment
- For chemical equipments, heat exchangers, off-shore platforms
- Cladding on carbon and low alloy steels

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


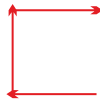
C	Mn	Si	Cr	Ni	Mo	N	Cu
0.04 max	0.50-2.0	1.0 max	21.0-24.0	7.5-10.0	2.5-4.0	0.08-0.20	0.50 max

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	690 min	20 min

With mixed gas chemical composition and mechanical properties will be higher.

PARAMETERS - PACKING DATA:

Ø , mm	Kg/Spool		
1.2	12.5	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions, Except Vertical Down: 
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20
80Ar+20CO ₂	18-25