



FCAW DUPLEX STAINLESS STEEL
MIGINOX FC 2209

GAS SHIELDED FLUX CORED WIRE FOR DUPLEX STAINLESS STEEL



CLASSIFICATION : AWS A/SFA 5.22 EN ISO 17633-A

E2209T1-1/4 T 22 9 3 N L R C/M 2

KEY FEATURES :

- Rutile based gas shielded duplex stainless steel FCW 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

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO ₂	10-20	10-20
80Ar+20CO ₂	18-25	10-20

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

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	Cr	Ni
Specification	0.04 max	0.50-2.0	1.0 max	21.0-24.0	7.5-10.0
	Mo	N	Cu	S	P
Specification	2.5-4.0	0.08-0.20	0.50 max	0.03 max	0.04 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	Voltage, V	Amperage, A	Kg/Spool
1.2	22 - 32	120 - 300	12.5
1.6	24 - 34	200 - 360	12.5

EQUIVALENT :

SMAW Electrode: **Betanox 4462**

GMAW Wire: **Miginox 2209**

GTAW Wire: **Tiginox 2209**