DESCRIPTION:
SFC-2209B is composite of 22%Cr-9%Ni-3%Mo-N duplex ferritic-austenitic stainless steels. Hardly any Bi constituent, the weld metal delivers low crack sensitivity because of ductility increased for high temperature working environments. Superior corrosion resistance and high strength enhance the weldability to achieve your work easier.

APPLICATIONS:
It is designed to weld stainless steel i.e. UNS S31803 (Alloy 2205). Especially for the high working temp. i.e. petrochemical heat exchangers.

NOTE ON USAGE:
1. Welding parts is required to be clean from dust, oil, and rusty.
2. Use 100%CO2 gas with G.F.R 20-25l/min and the gas purity requested 99.8% min.
3. DC (+) welding.
4. Take necessary protection for proper gas shielding during welding for ductility without porosity and less content of nitrogen & hydrogen.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.03
Manganese (Mn) 0.81
Silicon (Si) 0.49
Nickel (Ni) 8.71
Chromium (Cr) 22.35
Phosphorus (P) 0.024
Sulphur (S) 0.013
Molybdenum (Mo) 3.21
Nitrogen (N) 0.12
Bismuth (Bi) ≥10ppm

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
TS N/mm² 797.5
EL% 30

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2</th>
<th>1.6</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>F, HF</td>
<td>Vertical-up</td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td>23~33</td>
<td>24~30</td>
<td>25~38</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>130~220</td>
<td>120~180</td>
<td>200~300</td>
</tr>
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