

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-2209 is a duplex stainless steel comprised of austenite and ferrite steels, the weld metal contains 22%Cr-9%Ni-3%Mo-N.
- It possesses better corrosion resistance, strength, and toughness.
- It is suitable for Petrol Chemical Industry, Heat Exchanger, and UNS S31803 (as Alloy 2205).

NOTE ON USAGE :

- Use CO₂ within gas purity of 99.8% upward for gas shield, and the flow with 20~25 l/min.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (CO₂)

C	Mn	Si	P	S	Ni	Cr	Mo	N
0.031	1.00	0.53	0.025	0.007	8.75	22.80	3.30	0.11

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
786(80.2)	27

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters	1.2		1.6	
	F, H	V, OH	F, H	V, OH
Voltage (Volt)	23-36	22-26	28-36	-
Current (Amp)	130-250	120-160	180-300	-