DW-2209 PREMIARC™

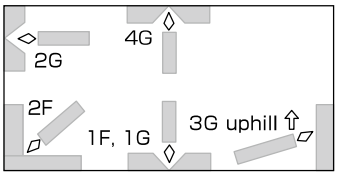
Flux cored wire

Features: ▪ Suitable for normal duplex stainless steel (S32205, S31803, etc.)

Classification: AWS A5.22 E2209T1-1/4

Shielding gas: CO_2 or Ar-CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (Ar-CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.5	1.0
Mn	0.7	0.5~2.0
P	0.02	0.04
S	<0.01	0.03
Ni	9.4	7.5~10.0
Cr	23.0	21.0~24.0
Mo	3.3	2.5~4.0
Cu	0.03	0.75
N	0.14	0.08~0.20

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical (Ar-CO_2)	Guaranty
0.2%YS (MPa)	630	-
TS (MPa)	815	690min.
El on 4d (%)	28	20min.
IV -40℃ (J)	60	-

Approvals

LR	S31803S (CHEM)
CWB	E2209T1-1, E2209T1-4

Note: Ar-CO_2

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill	4G
1.2	130~250	150~220	130~180	160~200