PF-S1D/US-2209 PREMIARC™

Flux and wire combination for duplex stainless

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

Classification: AWS A5.9 ER2209 (Wire only)

Type of flux: Bonded

Redrying of flux: 200~300℃ × 1h

Packaging data

Flux	Mesh	Can		
PF-S1D	12×65	20kg		
Volume mm		240W, 350H, 240L		
Wire	**ϕ mm**	**Spool**		**Coil**
US-2209	1.2	-	15kg	-
	1.6	10kg	15kg	-
	2.4	10kg	15kg	25kg
Volume mm		240W, 110H, 240L	285W, 110H, 285L	430W, 90H, 430L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.02	0.03
Si	0.36	0.90
Mn	1.42	0.50~2.00
P	0.01	0.03
S	<0.01	0.03
Ni	8.9	7.5~9.5
Cr	23.3	21.5~23.5
Mo	3.3	2.5~3.5
Cu	0.16	0.75
N	0.15	0.08~0.20

Note: [a] Single values are maximum.

Composition (all-weld metal mass%)

	Typical
C	0.02
Si	0.30
Mn	1.66
P	0.02
S	<0.01
Ni	9.0
Cr	23.1
Mo	3.3
Cu	0.16
N	0.14

All-weld mechanical properties

	Typical
0.2%YS (MPa)	618
TS (MPa)	798
El on 4d (%)	29
IV -40℃ (J)	61

Approvals

LR	S31803T, S31803M (CHEM)
DNV	MG
BV	2205TM
CCS	2205