



# CEWELD AA 2101 (Lean Duplex)

<b>TYPE</b>	Rutile fluxcored wire for welding lean duplex stainless steel. (Typ 2101, E2307)																			
<b>APPLICATIONS</b>	Very well suited for the chemical industries (e.g. bio fuel), the pulp and paper industry and also the food industry.																			
<b>PROPERTIES</b>	AA 2101 has excellent welding properties and was developed especially for the steel grade 1.4162/UNS S 32101. Due to the higher Mn and N – content of the Lean duplex base material, the slag viscosity and therefore the flow behaviour is changing and the welding bead is liquid for a longer time. The result is a very smooth seam.																			
<b>CLASSIFICATION</b>	AWS	A 5.22: E2307T1-1																		
	EN ISO	17633-A: T 23 7 N L P M21 2																		
	W.Nr.	1.4162																		
	F-nr	6																		
	FM	5																		
<b>SUITABLE FOR</b>	1.4162, 1.4362, 1.4482, 1.4062 X2CrMnNiN21-5-1, X2CrMnNiN22-5-2, X2CrMnNi 22-5-2, X2CrNiN23-4, X2CrMnNiMoN21-5-3, X2CrNiN23-4 UNS S32101, S32001, S32304, LEAN DUPLEX UNS S32304, LEAN DUPLEX UNS S32001, SAF 2304, 2001 ASME SA 240, ASME SA 790, Case 2418 LDX2101® (Avesta), Valbruna V234N, SS LD24																			
<b>APPROVALS</b>	CE																			
<b>WELDING POSITIONS</b>																				
<b>TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.45</td> <td>1.25</td> <td>0.02</td> <td>0.003</td> <td>24.5</td> <td>8</td> <td>0.2</td> <td>0.15</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	N	0.03	0.45	1.25	0.02	0.003	24.5	8	0.2	0.15	
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<b>REDRYING</b>	140°C / 24 hr																			
<b>GAS ACC. EN ISO 14175</b>	M21																			