



CEWELD SA 2209

TYPE Stainless steel Duplex filler metal for submerged arc welding

APPLICATIONS Boilers, tanks, vessels and similar objects that needs high strength and improved resistance against intergranular corrosion, pitting and stress corrosion.

PROPRIÉTÉS SA 2209 has high general corrosion resistance in media containing chloride and hydrogen sulfide. Combined with our fused flux FL 880 excellent results are obtained for both joining and cladding applications with self lifting slag and it leaves a fine rippled surface free from slag residues or pin holes. Also our agglomerated flux FL 838 can be used.


CLASSIFICATION

| | |
|--------|-----------------------|
| AWS | A 5.9: ER2209 |
| EN ISO | 14343-A: S 22 9 3 N L |
| W.Nr. | 1.4462 |
| F-nr | 5 |
| FM | 6 |

CONVIENT POUR **ISO 15608: 10.1-10.2 Austenitic > 24 % Cr ≤ 4% Ni, DUPLEX 2209, 22%Cr 9%Ni 3%Mo**
 1.4417, 1.4462, 1.4362, 1.4162, 1.4463, 1.4460, 1.4583
 X 2 CrNiMoSi 19 5, X 2 CrNiN 23 4, X 2 CrNiMoN 22 5 3, X10CrNiMoNb18-12
 316LN, 318LN
 UNS S31803, S32205, S32304
 SAF 2205 Fafer 4462, NKCr22, SM22Cr, Falc 223 UR 45N & UR 45N+, 2101, 2205, UR 35 N SAF 2304
 mix 1.4462 X2CrNiMoN22-5-3 mit P235GH/ P265GH, S255N, P295GH, S355N, 16Mo3

AGRÉMENTS CE

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | P | S | Cr | Ni | Mo | N |
|------|-----|-----|------|------|----|----|----|------|
| 0.02 | 0.8 | 1.5 | 0.02 | 0.02 | 22 | 9 | 3 | 0.15 |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | RT | -60°C | |
| As Welded | 570 | 780 | 25 | 80 | 40 | HRc |

ETUVAGE Not required

GAS ACC. EN ISO 14175



CEWELD SA 2209

SA 2209 2,4MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-415 | 25 | 8720663414601 |

SA 2209 3,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-415 | 25 | 8720663414243 |