

80%Ar - 20%CO₂/100%CO₂
 EN ISO 17633-A T 22 9 3 N L P C/M 1
 AWS A5.22 E2209T1-1/-4
 EN 1.4462

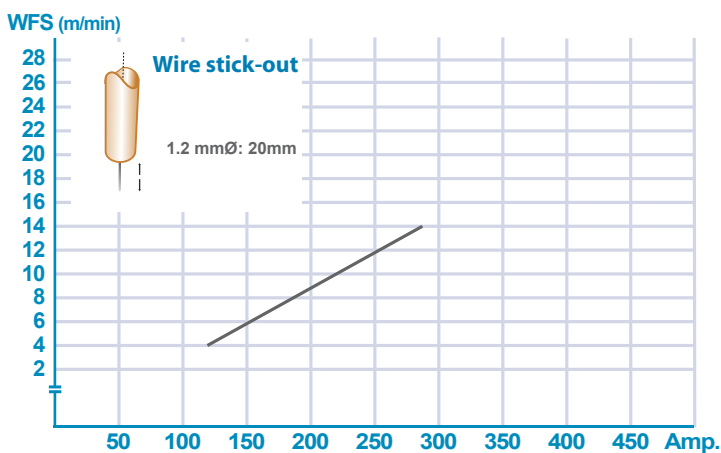
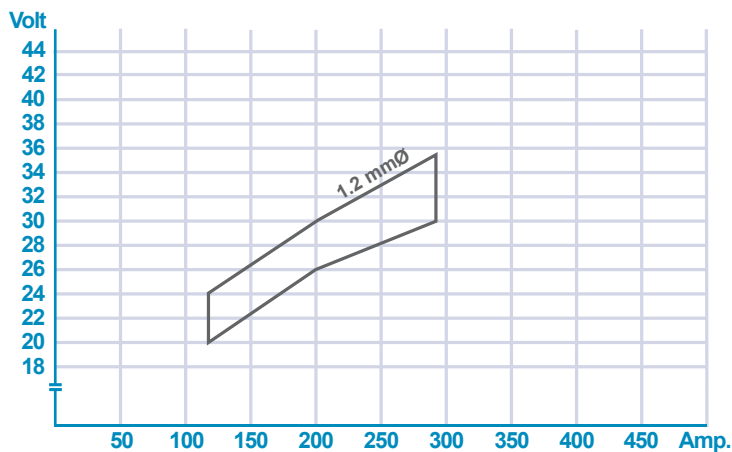
Description and Application

This is a rutile flux cored wire which operates with very stable, spatter free arc producing bright, smooth weld bead surfaces.

This wire is designed for welding duplex stainless steel such as AISI S31803 or EN 1.4462 stainless steels.

Due to the high nitrogen and high molybdenum in the weld metal, it is possible to obtain excellent resistance to chloride induced pitting corrosion.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FNW
0.03	0.58	0.78	0.019	0.008	9.4	22.9	3.5	0.15	-	42.7

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C	CV(J)-46°C
Guarantee	670	850	29	45	40
	min.450	min.690	min.20		

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
S31803	DUPLEX	-	4462S	-	-	TÜV