

# MIGINOX FC 2209

FCAW STAINLESS STEEL

AWS A/SFA 5.22 E2209T1-4

## CLASSIFICATION:

EN ISO 17633-A  
T 22 9 3 N L P M21 2

## KEY FEATURES:

- Rutile based gas shielded duplex stainless steel FCW wire
- Typical 22Cr/8.5Ni/3Mo/N alloy
- Austenitic-ferritic type weld deposit
- Stable arc, low spatter and easy slag removal
- Uniform and fine ripples
- Excellent combination of high strength and resistance to chloride induced SCC and pitting
- Radiographic weld quality

**APPROVALS:** CE

## TYPICAL APPLICATIONS:

- Welding of 2205, 2209 type duplex stainless steels and similar composition
- Pipelines transporting chloride bearing products and sour gases
- Cast pumps, Valve bodies and seawater handling equipment
- For chemical equipments, heat exchangers, off-shore platforms
- Cladding on carbon and low alloy steels


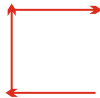
## CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo	N	Cu
0.04 max	0.50-2.0	1.0 max	21.0-24.0	7.5-10.0	2.5-4.0	0.08-0.20	0.50 max

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	690 min	20 min

## PARAMETERS - PACKING DATA:

<b>Ø , mm</b> 1.2 1.6	<b>Kg/Spool</b> 12.5 12.5	 <b>DCEP</b> <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	All Positions, Except Vertical Down: 
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<b>Shielding Gas</b> 80Ar+20CO <sub>2</sub>	<b>Gas Flow Rate, LPM</b> 18-25
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It can work with CO<sub>2</sub> shielding gas