

TOKO E2209T1-4

Flux Cored Wire for
Duplex Stainless Steel

Classifications:

AWS A5.22 E2209T1-4

EN ISO 17633-A-T 22 9 3 N L P M21 1

EN ISO 17633-B-TS 2209-F M21 1

Characteristics and Applications:

1. AWS-2209 is designed to weld duplex stainless steels such as UNS S31803 (Alloy 2205) with excellent pitting corrosion resistance, stress corrosion resistance and crack resistance.
2. The weld metal can be applied for operation temperature up to 250°C and is resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion.
3. Its typical applications include pumps, vessels, heat exchanger, chemical equipments and pipes processing chloride containing solutions.

Welding Position:



Typical Chemical Composition of Weld Metal:

Alloy (wt%)	C	Mn	Si	Cr	Ni	Mo	P	S	N	Cu
ISO Spec.	0.04	2.5	1.2	21.0-24.0	7.5-10.5	2.5-4.0	0.030	0.025	0.08-0.20	0.50
GFS-2209	0.021	0.93	0.72	23.92	9.25	3.22	0.015	0.002	0.11	0.02

Typical Mechanical Properties of Weld Metal:

Mechanical Property	Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	CVN J / °C
ISO Spec.	450	550	20	-
GFS-2209	655	824	27.0	-

Sizes Available and Recommended Parameters:

Size/mm	1.2	1.6
Volt	23-33	27-32
Amp	120-220	200-300
Stick Out(mm)	15-25	15-25
Gas Flow(l/min)	20-25	20-25

Notes on Usage:

1. Electric current : DC+
2. Clean up water, rust, oil on the base metal to avoid porosity and crack
3. Shielding Gas: 80%Ar+20%CO2
4. Proper protection on the welding place against wind is necessary during the outdoor welding.