



DUAL CORE 2209-T1

Stainless CORED/FCAW



Standards

EN/ISO-Standard - 17633-A

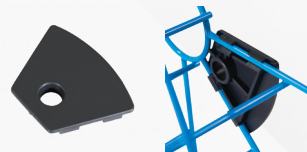
EN/ISO-Classification - T 22 9 3 N L P M21 1 / T 22 9 3 N L P C1 1

AWS-Standard - A5.22

AWS-Classification - E2209T1-4 - E2209T1-1

Features and Applications

- Rutile flux cored stainless steel wire for gas-shielded arc welding.
- 22% chromium - 9% nickel - 3% molybdenum - nitrogen - low carbon duplex stainless steel deposit.
- Specifically designed for out-of-position welding.
- Good slag detachment, attractive bead appearance and very good penetration.
- Excellent X-ray soundness.
- Maximum productivity for completion of vertical welds.
- Ideal for heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels.
- Precision layer wound for superior wire feeding characteristics.
- Suitable for wrought, forged or cast duplex stainless steels for service in the as-welded condition.
- **Test Certificates can be found online @wilkinsonstar247.com**



**Optional
Plastic Alignment Hole Clip**
Order Code: BS300-CLIP

Approvals

CE, UKCA

Typical Base Materials

S31803, X2CrNiMoN 22-5-3, S32205 - S32304, X2CrNiN 23 4

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - C1, M21

Polarity

DC (+)

Chemical Composition % (Typical)

C %	Mn %	Si %	Cr %	Ni %	Mo %	N %
0.03	0.9	0.5	23	9	3.1	0.13

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010201816	1.20	15	BS300 PLW	72

Welding Parameters

Ø mm	1.20
Current (A)	130-270
Voltage (V)	22-35

Mechanical Properties (Typical) - M21

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
820	630	27	60	-40°C
			40	-60°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.