

Dual Core 2209-T1

Stainless CORED/FCAW

Standards

EN/ISO-Standard - 17633-A

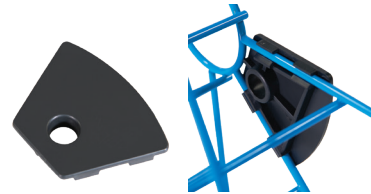
EN/ISO-Classification - T 22 9 3 N L P M21 1 / T 22 9 3 N L P C1 1

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

Typical Base Materials

UNS	EN Symbol
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 (+)

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.

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

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

