

Standards

TS EN ISO 17633-A	: T 22 9 3 N L P M21/C 1 1
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AWS A5.22	: E 2209 T1-1/-4

**Chemical Composition of
Weld Metal (Typical)**

C	Si	Mn	Cr	Ni	Mo	N
0.03	0.80	1.40	23.0	9.0	3.20	0.14

Mechanical Properties - (Typical): (With M21 gas)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-60°C)	Elongation ((L ₀ =5d ₀) (%))
630	780	32 J	28

Typical Base Material Grades

- (1.4462) X2CrNiMoN 22-5-3, (1.4362) X2 CrNiN 23-4, UNS S31803, S32205, J92295, S31500, S32304, S32404

Features and Applications

- Rutile type and rapid hardening flux cored wire
- Weld metal microstructure is austenite - ferritic
- The weld metal has an excellent resistance to stress corrosion, cracking and pitting
- Used in duplex stainless steel and similar materials
- Shielding Gas: CO₂ or M21

Welding Positions

Current Type

FCAW / D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100254	1.20	0.047"	15	D 300

Approvals: ELOXCOR S 2209: CDNV-GL, NK, RINA, SEPRO, CE