Cor-Revicod® 2209T1

Stainless rutile cored wire

Classification

AWS A5.22	:E 2209T1-4
ISO 17663	:T 22 9 3 N L P M 2

General description

Gas shielded flux cored wire electrode for positional welding of duplex stainless steel
Excellent weldability
Applicable up to a service temperature of 280°C
High resistance to general corrosion, pitting and stress corrosion conditions
High yield strength >500N/mm²

Welding positions

ISO/ASME	PA/1G	PB/2F	PC/2G	PF/3G up	PE/4G

Current type / Shielding gases

DC +
Ar+(>5-25)% CO_2 (EN 439:M21)
15-25 l/min

Approvals

Shielding gases	DNV
M21	+

Typical chemical composition of all weld metal, (w%)

Shielding gases	C	Mn	Si	Cr	Ni	Mo	N	FN
M21	0.03	0.7	0.6	22.9	9.2	3.4	0.14	40

Mechanical properties of all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact (ISO), J	
							+20°C	-20°C
Required	AWS A5.22			not required	min 690	min 20		
	ISO 17663			min 450	min 550	min 20		
Typical values after welding		M21	AW	660	830	29		40

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm) 1.2
Plastic spool S300	12.5	X

Identification Imprint: Cor-Revicod®2209T1

Cor-Revicod®22091: rev. EN 21

Materials to be welded

Steel	EN 10088-11-2	W.Nr.	ASTM/ACI A240	UNS
Duplex-stainless steels	X2 CrNiMoN 22-5-3	1.4462		S31803
		1.4417		S31500
	X3 CrNiMoN 27-5-2	1.4460		S31200
	X2 CrNiN 23-4	1.4362		S32304

Dissimilar joints such as un- and low alloyed steel to duplex stainless steel

Welding parameters, optimum fill, Shielding gases M21/C1

Diameter (mm)	Current / Voltage	Welding position				
		PA/1G	PB/2F	PC/2G	PF/3G up	PE/4G
1.2		100-250	100-250	100-200	130-180	

Remarks/ Application advice

Use for downhand welding Cor-Revicod® 2209T0