EXECUTIVE 2209P

STAINLESS STEEL

FLUX CORED WIRE TECHNICAL DATA SHEET

DESCRIPTION

Executive 2209P is an all position flux cored wire developed for welding 2205 duplex stainless steels as well as leaner grades of duplex stainless steel. Executive wire provides superior weldability, low spatter and smooth beads with easy slag removal. Designed for high deposition welding of multi-layer standing fillet welds.

Filler metal of this classification is used primarily to weld duplex stainless steels which contain approximately 22% chromium such as UNS S31803 and S32205. Deposits of this alloy have "duplex" microstructures consisting of an austenite-ferrite matrix. These stainless steels are characterized by high tensile strength, resistance to stress corrosion cracking, and improved resistance to pitting. If post weld annealing is required, this weld metal will require a higher annealing temperature than that required by the duplex base metal.

APPLICATIONS & FEATURES

Suitable for mechanized and robotic operation such as pipe work and general fabrication in offshore oil, gas, pulp and paper and chemical process industries.

This alloy offers high strength with good ductility and excellent corrosion resistance.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
0.03	22.50	9.70	3.25	0.95	0.60	0.03	0.015	0.20	0.14

Tensile Strength: 120,000 PSI min
Yield Strength: 95,000 PSI min
Elongation: 26%

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045"	24	130	225	
.045"	27	175	320	100% CO_2 or Ar + 20-25% CO_2
.045"	30	240	530	
.062"	27	195	152	
.062"	31	260	260	100% CO_2 or Ar + 20-25% CO_2
.062"	34	320	360	

*Shielding gas flow rate 35 to 50 CFH. For 100% CO_2 use two volts higher than shown

STANDARD PACKAGING

FCAW	33-lb plastic spools	1,980-lb pallet

CLASSIFICATION

AWS/SFA 5.22, Class **E2209T1-1/4**