TFW-2209P

AWS A5.22 E2209T1-4
EN ISO 17633-A-T 22 9 3 N L P M21 1

Characteristics and Applications:

TFW-2209P is suitable to duplex stainless steel such as UNS S31803 (Alloy 2205). The product features excellent pitting corrosion resistance, stress corrosion resistance and crack resistance. It is suitable for welding of heat exchanger, chemical equipments and pipes.

Notes on usage:

1. Before welding, oil, rusty, and moisture should be cleaned off the base material that should have the proper protection from the wind in welding site.
2. Use with mix gas (75～80% Argon and 25～20% CO_2).
3. Keep the product dry, while it is stored or delivered.

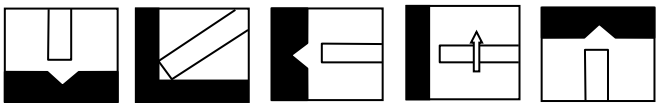
Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cr	Ni	Mo	N	Cu
AWS	≦0.04	0.5-2.0	≦1.0	≦0.04	≦0.03	21.0-24.0	7.5-10.0	2.5-4.0	0.08-0.20	≦0.75
EN ISO	≦0.04	≦2.5	≦1.2	≦0.030	≦0.025	21.0-24.0	7.5-10.5	2.5-4.0	0.08-0.20	≦0.5
Typical value	0.025	0.90	0.55	0.023	0.007	22.5	8.9	3.3	0.16	0.16

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation (%)
AWS	-	≧690(100)	≧20
EN ISO	≧450(65)	≧550(80)	≧20
Typical value	645(94)	790(115)	30

Welding position:



Sizes and recommended parameter range (DC＜+＞):
Stick out:15-20(mm),flow rate:20-25(l/min):

Position \ Diameter (mm)	1.2
F	150A-220A/24V-33V
H	140A-180A/25V-29V
V-UP	130A-180A/24V-29V
OH	150A-180A/25V-29V

FLUX CORED WIRES

TIENTAI
AN ILLINOIS TOOL WORKS COMPANY
No.6, Kaifa 4th Rd., Rende Dist., Tainan City 717, Taiwan
TEL:886-6-2663721 /FAX:886-6-2664301
E-mail:twtrad@itwweld.com
http://www.tientai.com