



# Cromacore 2209T1

FCAW - Flux cored arc welding  
Stainless Steel

Date: 2023-09-08  
Revision: 3

## Description:

Cromacore 2209T1 is suitable for welding duplex stainless steel such as UNS S31803 (Alloy 2205). Excellent pitting corrosion resistance, stress corrosion resistance and crack resistance. It is suitable for welding of heat exchanger, chemical equipment and pipes.

## Welding positions:



## Welding current:

DC+

## Deposition efficiency:

87%

## Shielding gas:

M21, 80% Ar + 20% CO<sub>2</sub>, 22-25 l/min

## Stick-out:

15-20 mm

## Ferrite content:

FN 37

## Corrosion resistance

Pitting resistance equivalent, PRE = 36

## Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			21,0	7,5
Typical	0,027	0,5	0,97	0,027	0,007	22,2	9,0
Max	0,04	1,0	2,0	0,030	0,025	24,0	10,0

	Mo	Cu	N
Min	2,5		0,08
Typical	3,2	0,08	0,14
Max	4,0	0,50	0,20

## Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:	≥ 500 MPa	715 MPa
Tensile Strength, Rm:	≥ 700 MPa	803 MPa
Elongation, A5	≥ 20%	27%
Impact energy, CV:	-20°C • 27 J	-20°C • 61 J

## Classification:

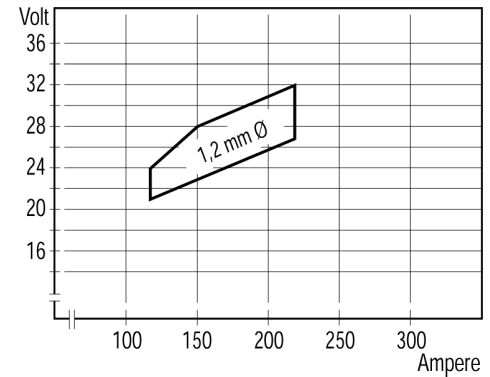
AWS A5.22  
ISO 17633-A

E2209T1-4  
T 22 9 3 N L P M 1

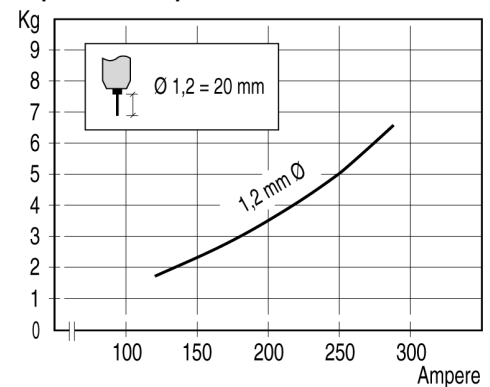
## Approvals:

CE

## Recommended parameter range:



## Deposition rate per hour:



## Product data:

Diam.mm	Product code	Spool weight
1,2	94781012	15 kg BS300
1,2	94782112	5 kg D200

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