

CSF-2209(P)

Duplex stainless steel

AWS A5.22 E2209T0(1)-1
JIS Z3323 TS2209-FB0(1)

Applications

CSF-2209(P) is suitable for welding of low carbon 22%Cr-5%Ni-2%Mo-0.15%N duplex stainless steel.

Characteristics

- (1) CSF-2209(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.

Notes on usage

- (1) The optimum flow of CO₂ for Shielding is 20~25ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO₂)

	C	Mn	Si	P	S	Cr	Ni	Mo	N	FN
CSF-2209	0.030	0.80	0.51	0.020	0.006	22.40	8.60	2.90	0.15	48
CSF-2209P	0.028	0.60	0.64	0.020	0.009	22.60	9.0	3.00	0.13	45

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO₂)

	YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)	
				0℃	-50℃
CSF-2209	692	802	26.5	62	42
CSF-2209P	680	790	27.0	65	45

Size & recommended current range (DC +)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm / min)
1.2(0.045)	150~300	24~33	20~60
1.6(0.062)	200~400	24~33	20~60

• Approval : CSF-2209P : ABS