

Inweld 2209T1-1/4 AP

AWS A5.22 E2209T1-1/4

Chemical Composition of Inweld 2209T1-1/4 AP

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.03	22.5	9.7	3.25	0.95	0.60	0.03	0.015	0.14	0.20

Single values are maximum unless otherwise specified.

Description and Applications

Inweld E2209T-1 is a flux-cored AISI 2209 Duplex type stainless steel alloy wire with exceptionally good operating characteristics. It is formulated for MAG welding of 23%Cr-9%Ni-3%Mo duplex stainless steel (2205) and this principal area of application is chemical plant and shipbuilding as well as nuclear plant industries. (ASTM A185 Gr.51, DIN 1.4462, JIS 329J1, UNS S31803). Inweld's 2209T-1 is a titanium type of flux cored wire for all position welding and it has a stable welding arc producing a weld with easy slag removal and minimal spatter.

Inweld's 2209T-1 is excellent in pitting corrosion resistance and stress corrosion cracking resistance. This flux cored wire will deposit welds at substantially higher welding currents than other stainless steel flux cored wires, which results in a higher deposition rate. This wire is formulated to use with 75% Argon/25% CO₂ shielding gas but straight CO₂ may also be used. The gas mixture will produce a smooth arc with virtually no spatter and slightly higher yield and tensile strengths than CO₂.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	120,000 psi
Yield Strength:	95,000 psi
Elongation:	26%

Recommended Parameters

FCAW (DCEP – Electrode +) 75% Ar / 25% CO₂ or 100% CO₂

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.045"	25-30	130-220
1/16"	25-29	170-300

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