

# SFC-2209

AWS A5.22 E2209T1-1  
JIS Z3323 TS2209-FB1  
EN ISO 17633-A T 22 9 3 N L P C/M 2

## FLUX CORED WIRES FOR STAINLESS STEEL

### DESCRIPTION :

SFC-2209 is designed to weld duplex stainless steels such as UNS S31803 (Alloy 2205) with excellent pitting corrosion resistance, stress corrosion resistance and crack resistance. The weld metal can be applied for operation temperature up to 250°C and is resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion.

### APPLICATIONS :

Typical applications include pumps, vessels, heat exchanger, chemical equipments and pipes processing chloride containing solutions.

### NOTE ON USAGE :

1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

### WELDING POSITION:



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :(Shielding Gas: 100% CO<sub>2</sub>)

Weld Metal Analysis :

Carbon (C)	0.031
Manganese (Mn)	0.85
Silicon (Si)	0.53
Phosphorus (P)	0.025
Sulphur (S)	0.015
Nickel (Ni)	8.75
Chromium (Cr)	22.25
Molybdenum (Mo)	3.25
Nitrogen (N)	0.11

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO<sub>2</sub>)

TS N/mm <sup>2</sup>	786
EL%	27

### APPROVALS :

ABS,BV,CCS,CE,DNV

### SUGGESTED WELDING PARAMETERS (DC <->)

Parameters	Diameter (mm)			
	1.2mm	1.6mm		
Welding Position	F, HF	V-UP, OH	F, HF	V-UP, OH
Voltage (Volt)	23 ~ 33	25 ~ 30	27 ~ 32	--
Current (Amp)	130 ~ 220	120 ~ 200	200 ~ 300	--