

KOBELCO

PREMIARC™

DW-2209

All positional flux cored wire for duplex stainless



Code Data

AWS A5.22 E2209T1-1, 4

Outstanding Features

- All heats contain high nitrogen content for higher strength and better corrosion resistance.
- High impact properties can be guaranteed even at -40°F (-40°C).
- DW-2209 has the option of being shielded by 75%Ar-25%CO₂ gas mixture or 100%CO₂ gas (75%Ar-25%CO₂ recommended).
- DW-2209 provides a smooth bead appearance, minimal spattering and slag is easily removability.

Typical chemistry of weld metal (75%Ar-25%CO₂)

C	Si	Mn	Cr	Ni	Mo	Cu	N	PRE	FN
0.024	0.55	0.89	22.96	9.68	3.28	0.06	0.14	36.0	40.5

PRE=Cr+3.3×Mo+16×N, FN=Ferrite Number by WRC Diagram(1992)

Typical mechanical property of weld metal (75%Ar-25%CO₂)

0.2%P.S (psi)	T.S (psi)	Elongation (%)	Impact value (ft-lbs)	
			-40 °F	0 °F
89,490	117,200	31	44 <28.1>	54 <41.9>

Test method: AWS A5.22, welding parameter: 200A-28V (0.045")

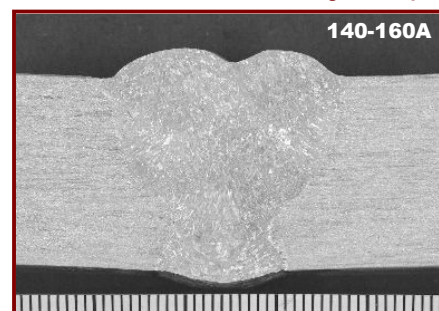
< >: Lateral expansion (unit=mils)

Pitting Corrosion Property

Test condition	Corrosion loss (g/m ² ·hr)	Judgment
68°F × 24hr	0.005	No Pitting
77°F × 24hr	0.032	No Pitting

Test method: According ASTM G48A

Macrostructure of butt joint (3G)



KOBELCO WELDING OF AMERICA INC.

Tel: 281-240-5600 Fax: 281-240-5625
<http://www.kobelcowelding.com>