

TFW-2209

JIS Z 3323 TS2209-FC1
AWS A5.22 E2209T1-1
EN 12073 T 22 9 3NL P C 2

Characteristics and Applications :

TFW-2209 is a flux-cored wire that is applicable for the welding of duplex stainless steel such as UNS S31803 (Alloy 2205). Excellent pitting corrosion resistance, stress corrosion resistance and crack resistance can be obtained. It is suitable for the weldings of heat exchanger, chemical equipments and pipes.

Notes on Usage :

1. 100% CO₂ shielding gas with 99.8% purity is recommended and the flow rate should be kept over 20L/min for the wire diameter is 1.2 and 1.6mm.
2. Clean the surface of base metal completely to prevent the contamination.
3. Trailer Shield is required to ensure the weld pool completely shielded until solidification is complete and no porosity problem.
4. The welding place should have the proper protection from wind to prevent generating the welding defects due to improper gas shielding.

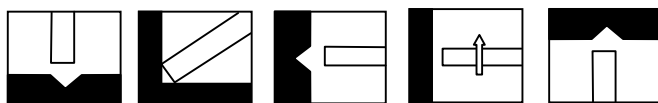
Typical Chemical Composition of Weld Metal (wt%) :

C	Mn	Si	P	S	Cr	Ni	Mo	Cu	N
0.029	0.75	0.68	0.025	0.009	22.57	8.36	3.08	0.08	0.16

Typical Mechanical Properties of Weld Metal :

TS (MPa)	EL %	CVN -46°C J
786	26	38

Welding position



Sizes and recommended current range (DC <+>)

Diameter (mm)	1.2	
Welding condition	A	V
F、HF	130-220	24-33
H	140-180	25-29
V-UP	130-160	24-28
OH	150-180	25-29

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