GB/T 17853 E2209LT1-1
AWS A5.22 E2209LT1-1
EN ISO17633-A:T 22 9 3 N L P M21

AK E2209LT1-1

Description: The welding wire is an ultra-low carbon austenitic-ferritic dual-phase stainless steel flux-cored welding wire, and the weld metal contains about 40% ferrite,so the deposited metal has the comprehensive properties of austenitic stainless steel and ferritic stainless steel. It has excellent stress corrosion resistance and is used as a new type of welding material in the petrochemical industry. The welding wire has small spatter, easy slag removal, beautiful shape, and can be welded in all positions.

Application: For welding 00Cr22Ni5Mo3N (SUS2205) stainless steel structure.

Typical Chemical Compostion(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.04	1.00	0.50-2.50	0.03	0.04	7.5-10.0	21.0-24.0	2.50-4.00	0.75
Actual Result	0.03	0.56	1.49	0.02	0.013	7.99	22.84	3.39	0.06

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥690	——	≥20	——
Actual Result	777	——	26	——

Recommended welding parameters:

Diameter/ mm	1.2	1.6		
Welding voltage/V	22-36	26-38	——	——
Welding current/A	120-260	200-300	——	——