

Characteristics and Applications:

FabCO 2209T1-1 is a flux-cored wire that is suitable 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 welding of heat exchanger, chemical equipment and pipes.

Notes on usage:

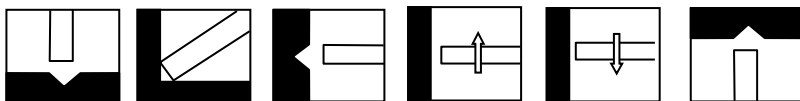
1. 100% CO₂ shielding gas with 99.8% purity is recommended.
2. Clean the surface of base metal completely to prevent the contamination.
3. The welding place should have the proper protection from wind to prevent generating the welding defects due to improper gas shielding.
4. Keep the product dry, while it is stored or delivered.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni	Mo	N
0.029	0.85	0.60	0.025	0.006	22.57	9.33	3.45	0.16

Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation (%)
786(114)	26

Welding position:**Sizes and recommended parameter range (DC<+>):**

Stick out: 15-20 (mm) , flow rate:20-25(l/min):

Diameter (mm)	1.2
Position	
F, HF	130A-220A/24V-33V
H	140A-180A/25V-29V
V-UP	130A-180A/24V-29V
V-down	150A-180A/25V-29V
OH	150A-180A/25V-29V

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