

## Flux Cored Wire for Stainless Steel

# KFW-2209

### Classification

AWS	A5.22	E2209LT1-1/4
JIS	Z3321	TS2209-FB1
EN	17633-A	T 22 9 3 NLP C1/M21 2
GB	T 17853	E2209LT1-1/4

Shielding Gas: CO<sub>2</sub> or Ar+20%CO<sub>2</sub>

### Applications and Features

- (1) Weld metal is 22.5% Cr-9.5% Ni-3% Mo-0.15%N.
- (2) It is ideal for welding 22% Cr duplex stainless steel, such as UNS S31803 (Alloy 2205).
- (3) It provides high resistance to general corrosion, pitting, and stress corrosion.
- (4) It has a bright golden bead appearance and good wettability.

### Welding Position

F (IG), H-Fillet (2F)

### Welding Instruction

- (1) For other instructions, please refer to Appendix D.
- (2) For extra information, please refer to Appendix F.

### Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : CO<sub>2</sub>)

C	Si	Mn	P	S	Cr	Ni
0.038	0.41	1.31	0.027	0.005	23.46	9.44

### Typical Mechanical Properties of Weld Metal (Shielding Gas : CO<sub>2</sub>)

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %
710(72.44)	24

### Size and Suggested Operating Range (DC+)

Diameter (mm)	F/H-fillet		V/OH	
	Amp	Volt	Amp	Volt
1.2	100~300	20~36	100~200	24~30
1.6	200~360	26~40	—	—