

COR™STAIN 2209 FC

DESCRIPTION

COR™STAIN 2209 FC is a flux-cored, duplex stainless steel wire formulated for open arc welding in the flat position. The arc action is a smooth, globular transfer, and the slag is easily removed. The resulting weld deposit exhibits moderate strength with excellent corrosion resistance.

APPLICATIONS

2209 FC is used for joining 22% chrome duplex stainless steels to themselves, or dissimilar combinations. Typical uses include marine, chemical, and petroleum applications requiring tenacious resistance to stress and pitting corrosion.

PROCEDURE

No preheat is required. Maintain a 300°F maximum interpass temperature. Annealing may be required to achieve a uniform hardness on multipass weldments.

WELDING PARAMETERS

	Size	Volts	Amps	Stickout
FC-O	.045"	24-28	100-140	1"
FC-O	1/16"	24-28	160-200	1.25"
FC-O	3/32"	26-30	240-280	1.5"

MECHANICAL PROPERTIES

Tensile Strength: 100,000 psi minimum
Elongation: 20% minimum

CLASSIFICATION

AWS A5.22, class E2209T0-3