

# FLUXINOX 22.9.3L

## Cored Wires Stainless and Heat resistant steels

Fluxinox 22.9.3L is an alloyed rutile flux cored wire, suitable for the joining and cladding of corrosion resistant ferritic-austenitic duplex-steels. The weld metal consists of about 30% ferrite and 70% austenite and is particularly resistant to pitting, crevice corrosion and stress corrosion cracking in chloride and hydrogen sulphide bearing media. Principal applications include the construction of chemical plants and offshore installations, for operating temperatures up to 250 °C.

Classification	
AWS	A5.22: E2209T0-4 / E2209T0-1
EN	12073: T 22 9 3 N L R M 3 / T 22 9 3 N L R C 3

Approvals	Grades
TÜV	
UDT	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.04	1.20	0.70	-	-	22	9	3	-	-	0.10	35-45

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 60 °C	Hardness
As Welded	≥ 450	≥ 690	≥ 20	≥ 32	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

### Materials

1.4462 (X2CrNiMoN22-5-3)

UNS S31803 - S31500 - S31200 - S32304

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



PA PB PC

**Packaging data:** K300 kg. 16

Diameters	1,2	1,6			
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