

FLUXINOX 22.9.3L-PF

Cored Wires Stainless and Heat resistant steels

Fluxinox 22.9.3 L-PF 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 cracking in chloride and hydrogen sulphide bearing media. Principal applications include the construction of chemical plants and offshore weldments for operating temperatures up to 250 °C. Due to its fast-freezing slag, Fluxinox 22.9.3 L-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E2209T1-4 / E2209T1-1
EN	12073: T 22 9 3 N L P M 1 / T 22 9 3 N L P C 1

Approvals	Grades
TÜV	

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 ²	Tensile Strength N/mm ²	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)

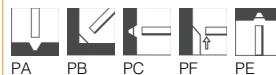
UNS S31803 - S31500 - S31200 - S32304

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg. 16

Diameters	1,2					
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