

# Cor-A-Rosta 4462

## Stainless rutile cored wire

### Classification

AWS A5.22-95 : E2209T0-4  
EN 12073-99 : T 22 9 3 N L R M 3

### General description

Gas shielded flux cored wire electrode for duplex stainless steel welding in downhand position

Excellent weldability

Applicable up to a service temperature of 280°C

High resistance to general corrosion, pitting and stress corrosion conditions

High yield strength >500N/mm<sup>2</sup>

### Welding positions



ISO/ASME PA/1G PB/2F PC/2G

### Current type/Shielding gas

Ar+ (>5-25%) CO<sub>2</sub> (EN 439: M21)  
15-25 l/min

### Approvals

Shielding gas	DNV	TÜV
M21	+	+

### Chemical composition (w%) and Ferrite Number (FN), typical, all weld metal

Shielding gas	C	Mn	Si	Cr	Ni	Mo	N	FN
M21	0.03	0.9	0.6	22.9	9.3	3.4	0.14	40

### Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) -20°C
Required:	AWS A5.22-95 EN 12073-99		not required min. 450	min. 690 min. 550	min. 20 min. 20	
Typical values	M21	AW	665	825	29	38

### Packaging and available sizes

Unit	Net weight (kg)	Size (mm)
Plastic spool S300	12.5	X

Cor-A-Rosta 4462: rev. EN 15

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## Materials to be welded

Steel grades	EN 10088-11-2	W.Nr.	ASTM / ACI A240	UNS
Duplex- stainless steels	X2 CrNiMoN 22 -5-3	1.4462		S31803
		1.4417		S31500
	X3 CrNiMoN 27-5-2	1.4460		S31200
	X2 CrNiN 23-4	1.4362		S32304

Dissimilar joints such as un- and low alloyed steel to duplex stainless steel

## Welding parameters, optimum fill passes in shielding gas M21/C1

Welding position	PA/1G	PB/2F	PC/2G
Diameter (mm)	Current (A)		
1.2	100-250	100-250	100-200

## Remarks/ Application advice

Use for positional welding Cor-A-Rosta P4462