Cor-A-Rosta P4462

Stainless rutile cored wire

Classification

AWS A5.22-95 : E2209T1-4
EN 12073-99 : T 22 9 3 N L P M 2

General description

Gas shielded flux cored wire electrode for positional welding of duplex stainless steel
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/mm²

Welding positions

ISO/ASME PA/1G PB/2F PC/2G PF/3G up PE/4G

Current type/Shielding gas

DC +
Ar+ (>5-25%) CO_2 (EN 439: M21)
15-25 l/min

Approvals

Shielding gas	DNV
M21	+

FCAW

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

Shielding gas	C	Mn	Si	Cr	Ni	Mo	N	FN
M21	0.03	0.7	0.6	22.9	9.2	3.4	0.14	40

Mechanical properties, typical, all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact ISO-V(J) -20°C
Required:				not required	min. 690	min. 20	
	AWS A5.22-95			min. 450	min. 550	min. 20	
Typical values	EN 12073-99	M21	AW	660	830	29	40

Packaging and available sizes

Unit	Net weight (kg)	Size (mm) 1.2
Plastic spool S300	12.5	X

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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	PF/3G up
Diameter (mm)	Current (A)			
1.2	100-250	100-250	100-200	130-180

FCAW

Remarks/ Application advice

Use for downhand welding Cor-A-Rosta 4462

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