CIGWELD

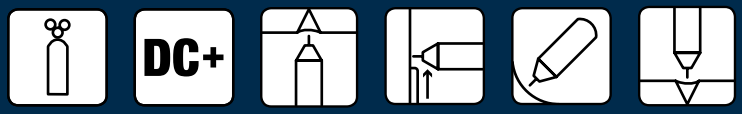
AN ESAB BRAND

FCAW

VERTI-COR 2209

PRODUCT DATA SHEET

VERTI-COR STAINLESS STEEL FLUX CORED WIRES; 2209 - ALL POSITIONAL CAPABILITIES



VERTI-COR 2209

- Vacuum Sealed in Aluminised Plastic Packs.
- Formulated for CO_2 or Argon + 18-25% CO_2 Shielding gases.
- High Deposition Rate Welding of Stainless Steels.

CLASSIFICATIONS:

AWS/ASME-SFA A5.22:	**E2209T1-1 (CO_2) / E2209T1-4 (Ar + 18-25%CO_2).**

RECOMMENDED SHIELDING GAS:

AS 4882:	**ISO 14175 / AWS A5.32:**
SG-C	**C1**
SG-AC-18, or SG-AC-20	**M21**
Welding grade CO_2 or Ar+CO_2 (18-25%)	

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	USING CO_2:	**ARGON + 18-25% CO_2:**
0.2% Proof Stress	**610 MPa**	**650 MPa**
Tensile Strength	**825 MPa**	**820 MPa**
Elongation	**32%**	**25%**
CNV Impact Values	**50J@-46 C**	**52J@-46 C**

TYPICAL ALL WELD METAL ANALYSIS:

USING WELDING GRADE CO_2:			
C:	**0.04%**	Ni	**8.5%**
Mn:	**1.10%**	Mo:	**3.5%**
Si:	**0.60%**	P:	**0.02%**
Cr:	**22.8%**	S:	**0.002%**

CIGWELD Data Sheet **VERTI-COR 2209 V1-2023**
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DESCRIPTION AND APPLICATIONS:

Verti-Cor 2209 is an all-positional duplex flux cored wire designed for the welding of 22Cr-5Ni-2Mo-0.15N duplex stainless steel commonly known as 2205. Commercial designations for such steels include SAF 2205 (Sandvik), 2205 (Avesta). The rutile type flux core gives smooth arc transfer characteristics and very low spatter levels with both CO_2 and Argon + 18-25% CO_2 shielding gases. The fast freezing slag gives excellent weld pool control resulting in smooth mitre to slightly convex fillet welds in the flat, horizontal-vertical, vertical-up and overhead welding positions.

Actual weld metal mechanical properties achieved with Verti-Cor wires are influenced by many factors including base metal analysis/heat input used, shielding gas selection, number of weld passes and run placement etc. Please contact CIGWELD for welding procedure recommendations.

COMPARABLE CIGWELD PRODUCTS:

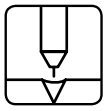
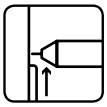
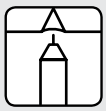
Comweld 2209 GAS/TIG rod

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	722930

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO_2 shielding gas with a flow rate of 15-20 litres/min.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING POSITION	
1.2	150-250	23-28	15-20		Flat
1.2	150-200	23-28	15-20		HV Fillet
1.2	120-180	22-27	15-20		Vertical up
1.2	140-180	22-27	15-20		Overhead

These machine settings are a guide only. Actual voltage, welding current and CTWD used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

P/N: 722930

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