



Smoothcor 2209-AP

CLASSIFICATIONS: E2209T1-1/4 per AWS A5.22, ASME SFA 5.22

DESCRIPTION: Smoothcor 2209-AP is a flux cored, all position electrode designed to weld duplex stainless steels of 22Cr-5Ni-2Mo-N type. This wire normally gives ferrite in the range of 30-60 FN.

APPLICATIONS: Smoothcor 2209-AP is well suited for welding similar materials in the chemical and fertilizer industries, off-shore pipelines, sour gas lines, etc... The weld metal exhibits high strength with excellent corrosion resistance, especially to pitting attack from chlorides in sea water.

DIAMETERS: .045", 1/16"

SHIELDING GAS: 100% CO₂, 75-80% Ar / balance CO₂, 35-50 cfh

WELDING POSITIONS: All position

CHARACTERISTICS:

- Exceptional corrosion resistance.
- Superb performance in all positions.
- Provides smooth, stable arc with very low spatter.
- Slag removes easily.
- Bead appearance is shiny, smooth and silvery.

TYPICAL MECHANICAL PROPERTIES	
	CO ₂ *
Ultimate Tensile Strength (psi)	121,000
Yield Strength (psi)	98,000
Percent Elongation	24
CVN (ft-lb f) @ -20° F	35

**Strength levels will be slightly higher with AR+20-25% CO₂*

TYPICAL DEPOSIT COMPOSITION *							
Wt%	C	Mn	Si	Ni	N	Cr	Mo
	0.03	1.00	0.55	9.0	0.15	23.00	3.00

**Ferrite Number (WRC, 1992) ~40*

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

Unibrazed Corporation 1050 Penner Crest Houston, TX 77055 1-800-364-6900

www.unibrazed.com