

AWS	A5.22 E2209T1-1
EN	EN12073 T 22 9 3NL P C 2
JIS	Z3323 TS2209-FC1

Characteristics:

LFC-2209 is a flux cored wire designed to weld duplex stainless steel such as UNS S31803 (Alloy 2205). With excellent pitting corrosion, stress corrosion resistance and crack resistance.

Applications:

It is suitable for welding of heat exchanger, chemical equipment, pumps, vessels and pipes processing chloride containing solutions.

Notes on Usage:

1. Use 100% CO₂ shielding gas.
2. Trailer Shield is required to ensure the weld pool completely shield until solidification is complete and no porosity problem.
3. Follow the recommended welding parameter to achieve good sound welds.
4. To prevent the welding defects due to improper gas shielding, the welding place should have the proper protection from wind.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni	Mo	Cu	N
0.029	0.85	0.68	0.025	0.009	22.57	8.36	3.2	0.08	0.16

Typical mechanical properties of weld metal

TS N/mm ²	EL %
786	26

Welding Position



Sizes and recommended current range (DC <+>)

Diameter (mm)	1.2 mm			
	Parameters			
Welding Position	F, HF	H	V-UP	OH
Voltage(Volt)	24-33	25-29	24-28	25-29
Current(Amp)	130-220	140-180	130-160	150-180
Stick out(mm)	15-20	15-20	15-20	15-20
Flow rate(l/min)	20-25	20-25	20-25	20-25
Weight per spool (kg)	12.5			