

MIG/MAG Cored Wires Stainless and Heat resistant steels

FLUXINOX 22 9 3L PF is an alloyed rutile flux cored wire, suitable for the joining and cladding of corrosion resistant ferritic-austenitic duplex steels. The weld metal consists of about 30% ferrite and 70% austenite and is particularly resistant to pitting, crevice corrosion cracking in chloride and hydrogen sulphide bearing media. Principal applications include the construction of chemical plants and offshore weldments for operating temperatures up to 250 °C. Due to its fast-freezing slag, FLUXINOX 22 9 3 L PF is used for welding in the horizontal (PC), overhead (PE) and vertical-up (PF) positions.

Classification	
EN ISO	17633-A: T 22 9 3 N L P C 1
EN ISO	17633-A: T 22 9 3 N L P M 1
AWS	A5.22: E2209T1-1
AWS	A5.22: E2209T1-4

Approvals	Grade
DNV	DUPLEX
GL	4462
LRS	S31803S
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Mo	N	Ferrite
≤ 0.04	0.8	0.5	22.5	9	3	0.1	38-60

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-20 °C	-30 °C
As Welded	≥ 550	750 - 900	≥ 24	≥ 40	≥ 35

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : C1, M21

Materials

UNS S31803 - S31500 - S31200 - S32304

1.4462 (X2CrNiMoN22-5-3)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	●
1.2	●