

Stainless Steel Gas Shielded type FCW

KF2209

AWS A5.22 E2209T1-1/-4

Product Features:

- GMX2209 is design to weld similar type of duplex stainless steel.
- The alloy has good resistance to stress corrosion cracking and pitting corrosion attack.
- Smooth arc, low spatter loss and easy slag removal.

Applications:

- Suitable for welding of duplex stainless steel such as 2205.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Ni	Mo	S	P	N
0.03	0.6	1.5	23.1	9.1	3.2	0.009	0.018	0.140

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
620	810	28.3

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat position	160~250	220~300
	Vertical up position	90~130	----
Voltage	Flat position	22~32	24~30
	Vertical up position	20~24	----
Shielding Gas		CO ₂ /Mixed Gas	CO ₂ /Mixed Gas

Note:

- Use general CO₂ welding machine with proper feed roller pressure.

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CMI

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