

INERTFIL 22 9 3

Drôt pre zváranie TIG/MAG

Welding rod/wire electrode for TIG/MAG-welding process

Pręty/druty do spawania metodami TIG/MAG



Standards:

DIN EN 12072

DIN 8556

AWS/ASME SFA-5.9

Comparable No. of Materials:

G 22 9 3 N L

(SG X 2 Cr Ni Mo N 22 9 3)

ER 2209

(1.4462)

SK Vlastnosti a použitie:

Feriticko-austenitický zvärací drôt pre zváranie duplexných ocelí a vysoko legovaných CrNi ocelí s nelegovanými a nízko legovanými do StE 355 metódou TIG a MAG pri prevádzkových teplotách do 250 °C. Čistý zvarový kov má podiel feritu od 25 do 30 % a je odolný voči korózii pod napätím, medzikryštalickej korózii a jamkovej korózii. Heterogénne spoje 1.4462 a 1.4583 s H11, H111, 17 Mn4, StE 255 až StE 355.

GB Applications and properties:

Ferritic-austenitic welding rod or wire electrode for TIG/MAG-welding of Duplex steels, as well as joining of high-alloy Cr Ni-steels to unalloyed and low-alloy steels up to grade StE 355, subject to operating temperatures up to 250 °C.

POL Zastosowania i własności:

Ferrytyczno-austenityczne pręty/druty do spawania TIG/MAG stali typu duplex, jak również do łączenia stali stopowych Cr-Ni ze stalami niestopowymi lub nisko-stopowymi aż do gatunku StE 355 pracującymi w zakresie temperatur do 250°C.

Materials for instance:

No. of Materials	EN-Designation
1.4462	X2CrNiMoN22-5-3

Approvals:

TÜV

Rod and wire analysis correspond to all-weld metal analysis (typical values in %)

C	Si	Mn	Cr	Ni	Mo	N	P	S
0,02	0,50	1,70	23,00	9,00	3,00	0,15	≤0,030	≤0,020

Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	0,2 % Proof stress [N/mm ²]	Tensile strength [N/mm ²]	Elongation A ₅ [%]	Impact energy ISO-V [J]
				+20 °C
AW	≥450	≥600	≥26	≥80

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:

DIN EN 439 - I1 in TIG – welding

DIN EN 439 - M13 in MAG – welding

Shielding gas acc. to DIN EN 439:

Welding rod for TIG-welding:

Wire electrode for MAG -welding:

Consumption:

I1 (ARCAL 1)

M12 (ARCAL 12), M13 (INARC S 3)

TIG = approx. 10 l/min, MAG = approx. 15 l/min

Form of delivery:

Welding rods				
Dia. [mm]	1,6	2,0	2,4	3,2
Length [mm]	1000			
Approx. Weight of packet [kgs]	10			

Wire electrodes			
Dia [mm]	0,8	1,0	1,2
Wire cage reel K300 [kgs]	15		

Further forms of delivery on request.

Type of current/Polarity/Welding positions:

