

# Cor-A-Rosta 4462

## Stainless steel rutile cored wire

### Classification

AWS A5.22 : E2209T0-1/-4  
ISO 17663-A : T 22 9 3 N L R M 3

### General description

Gas shielded flux cored wire electrode for duplex stainless steel welding in downhand position

Excellent weldability

Applicable up to a service temperature of 250°C

High resistance to general corrosion, pitting and stress corrosion conditions

High yield strength > 500 N/mm<sup>2</sup>

M21 shielding gas is recommended

### Welding positions



ISO/ASME PA/1G PB/2F PC/2G

### Current type/Shielding gas (ISO 14175)

DC +

M21 : Mixed gas Ar+ (>15-25%) CO<sub>2</sub>

C1 : Active Gas 100% CO<sub>2</sub>

Amount : 15-25 l/min

### Approvals

Shielding gas	DNV	GL	TÜV
M21	308LMS	4550S	+

### Chemical composition (w%) and Ferrite Number (FN), Typical, all weld metal

Shielding gas	C	Mn	Si	Cr	Ni	Mo	N	FN (acc. WRC 192)
M21	0.03	1.2	0.7	23	9.2	3.1	0.12	40

### Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) -20°C	-50°C
Required: AWS A5.22			not required	min. 520	min. 25		
ISO 17663-A			min. 350	min. 550	min. 25		
Typical values	M21	AW	630	800	29	40	30

### Packaging and available sizes

Unit type	Diameter (mm)
15 kg spool S300	X

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**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request

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## Materials to be welded

Steel grades	EN 10088-1/-2/-4	Mat. Nr	ASTM / ACI A240	UNS
<b>Duplex stainless steels</b>				
	X2 CrNiMoN 22 -5-3	1.4462		S31803
		1.4417		S31500
	X3 CrNiMoN 27-5-2	1.4460		S31200
	X2 CrNiN 23-4	1.4362		S32304
	X2 CrMnNi21-5-1	1.4162		S32101

Dissimilar joints such as un- and low alloyed steel to duplex stainless steel

## Welding parameters, optimum fill passes in shielding gas M21

Diameter (mm)	Welding positions		
	PA/1G	PB/2F	PC/2G
1.2	100-250A	100-250A	100-200A

## Remarks/ Application advice

Use for positional welding Cor-A-Rosta P4462  
Welding with Heat-Input max. 2.5 kJ/mm  
Interpass temperature max. 150°C