

Cor-A-Rosta P4462

Stainless steel rutile cored wire

Classification

AWS A5.22 : E2209T1-1/-4
ISO 17663-A : T 22 9 3 N L P M 2

General description

Gas shielded flux cored wire electrode for positional welding of duplex stainless steel

Excellent weldability

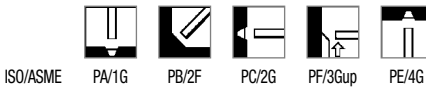
Applicable up to a service temperature of 250°C

High resistance to general corrosion, pitting and stress corrosion conditions

High yield strength > 500 N/mm²

M21 shielding gas is recommended

Welding positions



Current type/Shielding gas (ISO 14175)

DC +

M21 : Mixed gas Ar+ (>15-25%) CO₂

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 ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						-20°C	-50°C
Required: AWS A5.22			not required	min. 690	min. 20		
ISO 17663-A			min. 450	min. 550	min. 20		
Typical values	M21	AW	630	800	29	65	55

Packaging and available sizes

Unit type	Diameter (mm)
15 kg spool S300	X

Cor-A-Rosta P4462: rev. EN 24

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Materials to be welded

Steel grades	EN 10088-1/-2/-4	Mat. Nr	ASTM / ACI A240	UNS
Duplex stainless steels				
	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/C1

Diameter (mm)	Welding positions			
	PA/1G	PB/2F	PC/2G	PF/3G up
1.2	100-250A	100-250A	100-200A	130-180A

Remarks/ Application advice

Use for downhand welding Cor-A-Rosta 4462

Welding with Heat-Input max. 2.5 kJ/mm

Interpass temperature max. 150°C