



Lean Duplex 2101 FCW

EN ISO 17633-A: T 23 7 N L R M21 3 – T 23 7 N L R C1 3

DESCRIPTION

Rutile flux cored stainless steel wire for welding wrought, forged or cast lean duplex stainless steels for service in the as-welded condition. Heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels.

WELDING POSITIONS



CURRENT

DC +

GAS

M21

BASE MATERIAL

Stainless steels, duplex stainless steels
1.4362, 1.4162, 1.4062

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
750	600	28	-50°C: 35

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Ni	Mo	N	Cu
0,03	1,4	0,6	24	8,5	0,2	0,2	0,3

PACKAGING

Dimension (mm)	1,2		
Spool/drum (kg)	15		
Volt (V)	23-35		
Ampere (A)	100-270		
Stick out (mm)	12-25		
Gas flow (l/min)	10-20		