

# GFC 2209

## IDENTIFICATION

GFC 2209, E2209T1-1/4

## CLASSIFICATION

AWS/SFA 5.22: E2209T1-1/4, EN ISO 3581: E 22 9 3 N L B

## DESCRIPTION

GFC 2209 is a rutile type flux cored wire for all position welding with CO<sub>2</sub> & mixed gas. As deposition rate is higher than solid wire and MMA electrode highly efficient welding can be performed.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Mo	N
0.04 max	0.5 - 2.0	0.6 max	21.0 - 24.0	7.5 - 10.0	2.5-4.0	0.20 max

## MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)
690 min	20 min

## TYPICAL APPLICATIONS

- Off-shore platform pipe work, pipelines transporting chloride bearing products or sour gas and process vessels for chlorine environments.
- ASTM A 182 Gr. F 51
- USN S 31803
- DIN 1.4462
- Chemical and petrochemical process industries.

## SPECIAL INSTRUCTIONS:

- Proper preheating (50 - 150°C) and interpass temperature must be adopted in order to release hydrogen which may cause crack in weld metal.
- Both 100% CO<sub>2</sub> and mixed (Ar + 20-25% CO<sub>2</sub>) gas are useful.

**SHIELDING GAS :** CO<sub>2</sub> / (Ar + 20-25% Co<sub>2</sub>)

## PACKING PARAMETERS

Size (mm)	Amps DC (+)	Weight / Spool (kg)
1.2	120 - 300	12.5
1.6	180 - 400	12.5