

# LEXAL T 22 9 3 N

## MIG/MAG Cored Wires

Stainless and Heat resistant steels

SAF-FRO

LEXAL T 22 9 3 N is an alloyed rutile flux cored wire, suitable for the joining and cladding of corrosion resistant ferritic-austenitic duplex steels. The weld metal consists of about 30% ferrite and 70% austenite and is particularly resistant to pitting, crevice corrosion cracking in chloride and hydrogen sulphide bearing media. Principal applications include the construction of chemical plants and offshore weldments for operating temperatures up to 250 °C. Due to its fast-freezing slag, LEXAL T 22 9 3 N is used for welding in the horizontal (PC), overhead (PE) and vertical-up (PF) positions.



Classification	
EN ISO	17633-A: T 22 9 3 N L P C 1
EN ISO	17633-A: T 22 9 3 N L P M 1
AWS	A5.22: E2209T1-1
AWS	A5.22: E2209T1-4

Approvals				
BV	DNV	GL	LRS	RINA
	DUPLEX	4462	S31803S	2209 S

CE

### Chemical analysis (Typical values in %)

	C	Mn	Si	Cr	Ni	Mo	N	Ferrite
All weld metal	≤ 0.04	0.8	0.5	22	9	3	0.1	38-60

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-20 °C	-30 °C
As Welded	≥ 550	≥ 750	≥ 24	≥ 40	≥ 35

Gas test: 82% Ar+18% CO<sub>2</sub>

**Shielding Gas** - EN ISO 14175 : C1, M21

### Materials

UNS S31803 - S31500 - S31200 - S32304

1.4462 (X2CrNiMoN22-5-3)

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+

