

# FLUXINOX 22.9.3L-PF



**Cored Wires**  
**Stainless and Heat resistant steels**

Fluxinox 22.9.3 L-PF 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, Fluxinox 22.9.3 L-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E2209T1-4 / E2209T1-1
EN	12073: T 22 9 3 NLPM 1 / T 22 9 3 NLPC 1

Approvals	Grades
TÜV	

**Analysis of all-weld metal (Typical values in %)**

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
\$ 0.04	1.20	0.70	-	-	22	9	3	-	-	0.10	35-45

**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) - 60 °C	Hardness
As Welded	≥ 450	≥ 690	≥ 20	≥ 32	-

Gas test: Acc. To EN 439: M21

**Shielding Gas:** Acc. To EN 439: M21 or C1

**Materials**

1.4462 (X2CrNiMoN22-5-3)

UNS S31803 - S31500 - S31200 - S32304

**Storage**

Keep dry and avoid condensation

**Current condition and welding position**

DC+

PA PB PC PF PE

**Packaging data:** K300 kg, 16

Diameters	1.2mm				
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Diam.	15 kg Spool
1.2mm	OERFI2293L-PF12

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