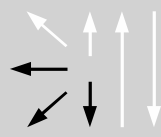


Classifications										
EN ISO 17633-A					AWS A5.22					
T 23 7 N L R M21 3					E2307T0-4					
T 23 7 N L R C1 3					E2307T0-1					
Characteristics and typical fields of application										
<p>BÖHLER CN 24/9 LDX-FD is a rutile flux cored wire for welding ferritic-austenitic lean- duplex stainless steels. It provides excellent weldability in flat and horizontal position. The weld metal has a high strength and medium corrosion resistance and is mainly intended for application such as bridge building, civil engineering, plant engineering in the paper industry, storage tanks, containers etc. The filler material is over alloyed with respect to nickel to ensure the right ferrite balance in the weld metal. The corrosion resistance is comparable with the steel AISI 304. The filler material is suitable for service temperatures from -50°C to +250°C.</p>										
Base materials										
1.4162 X2CrMnNiN21-5-1, UNS S32101										
1.4362 X2CrNiN23-4, UNS S32304, and other comparable materials										
Typical analysis of all-weld metal (wt.-%)										
	C	Si	Mn	Cr	Ni	Mo	N	Ferrite acc. to WRC-92		
wt-%	0.03	0.6	1.3	24.0	9.0	0.4	0.13	≥ 30		
Mechanical properties of all-weld metal										
Condition		Yield strength R <sub>p0.2</sub>		Tensile strength R <sub>m</sub>		Elongation A (L <sub>0</sub> =5d <sub>0</sub> )		Impact work ISO-V KV J		
		MPa		MPa		%		+20°C	-50°C	
u		550 (≥ 450)		755 (≥ 570)		28 (≥ 20)		60	44	
u untreated, as-welded – shielding gas Ar + 18% CO <sub>2</sub>										
Operating data										
		Polarity: DC ( + )		Shielding gases: M1 – M3; C1		Redrying if necessary: 150°C / 24 h		ø (mm) 1.2	Amps A 130 – 280	Voltage V 23 – 34
Interpass temperature: ≤ 6 mm wall thickness 150°C; ≥ 10 mm wall thickness max. 200°C Heat input: 0.5 – max. 2.0 kJ / mm. The gas flow should be 15 – 18 l / min.										
Approvals										
TÜV (13027.), CE										