

ER2209

AWS A5.9 ER2209

ISO 14343:2009: (22 9 3 N L)

Description:

ER2209 is used to weld 22% Cr/ 5% Ni duplex stainless steels. 2205 Duplex base material shows higher strength compared with standard austenitic stainless steels, such as 316L. This material possesses good general corrosion resistance in a wide range of environments, but also has high resistance to pitting attack in chloride environments, such as sea water

Diameters:

0.8mm,0.9mm,1.0mm,1.2mm.

Typical Mechanical Properties:

Tensile strength(MPa):	740
Yield strength(MPa):	635
Elongation(%):	42

Typical Chemical Composition:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.02	1.7	0.012	0.008	0.40	8.6	22.5	3.2	0.13

Welding Current:(DC+)

Diameter(mm)	0,8	0,9	1,0	1,2
Current/A	55-160	65-220	80-240	100-300
Voltage/V	15-24	15-28	15-28	15-29

Note:

- 1.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
- 2.Shield Gas:Ar+0.5-5%CO₂ or Ar+0.5-3%O₂.
- 3.Gas speed:20-25L/Min
- 4.DC+ connection; Arc length:4-6mm.
- 5. Tig rods ER2209 1.6mm, 2.0mm, 2.4mm, 3.2mm available**