



TIG/MIG 2209

STAINLESS STEEL

DESCRIPTION

GMAW Wire (MIG) and GTAW (TIG) with very low carbon content used for the welding of Duplex (Austeno-ferritic) steels type like 2205, 2304, etc. Very good in severe corrosion environment (pitting, crevice and stress corrosion, etc.)

CLASSIFICATION

AWS A5.9: **ER2209**

TYPICAL APPLICATIONS

Used for pumps, vessels, piping systems, and others attacked by chloride containing solutions. Also good for impellers and other components which require high strength combined with corrosion resistance.

CHARACTERISTICS

- Excellent weldability characteristics
- Stable arc with low spatter

MECHANICAL PROPERTIES

Tensile strength: > 117 000 psi (800 MPa)
 Yield Strength: > 87 000 psi (600 MPa)
 Elongation: > 28%

WELDING PARAMETRES

Process	Diameter	Voltage	Intensity	Gas flow	Shielding gas
GMAW MIG	0.9 mm (035")	29 – 33	160 - 180	30 - 50 CFH	Argon
	1.2 mm (045")	29 – 33	180 - 220		Argon Mixture
GTAW TIG	1.6 mm (1/16")	CC-		30 - 40 CFH	Argon
	2.5 mm (3/32")				Argon + Helium
	3.2 mm (1/8")				

Also available in electrode **INOX 2209** and FCAW **FC 2209-AP**.

Rev. 21_08

Specialized welding alloys and technology. For technical assistance or for ordering: