



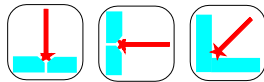
Duplex 2209 SAW

AWS A 5.9: ER2209 ISO 14343-A: S 22 9 3 N L

DESCRIPTION

Stainless steel wire for welding wrought, forged or cast duplex stainless steels for service in the as-welded condition. Heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels.

WELDING POSITIONS



CURRENT

DC+

FLUX

MF 300, MF 400

BASE MATERIAL

1.4462, 1.4362, 1.4062, 1.4162

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>

WELD METAL COMPOSITION(%)

C	Si	Mn	Ni	Cr	Mo	N
0,01	0,5	1,5	8,6	22,5	3,3	0,17

PACKAGING AND WELDING PARAMETERS

Dimension(mm)	2,0	2,4	3,2	4,0
Spool size(kg)	25/300	25/300	25/300	25/300

EQUIVALENT FILLER METALS

MMA	Meltolit Duplex 2209 E
TIG	Meltolit Duplex 2209 XT
FCW	Meltolit Duplex 2209 FCW /FCW-PW
MIG	Meltolit Duplex 2209 XM