

TIG 2209



Classification

EN 12072 : W 22 9 3 NL
AWS A5.9 : ER2209

Material N°: 1.4462

Description & Applications

Very low carbon content solid rod for joining Duplex steels (austenitic-ferritic microstructure)
Resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	N ₂	P	S	Fe
0.012	0.5	1.7	23.0	8.8	3.2	0.14	<0.02	<0.01	Base

All Weld Metal Mechanical Properties

Rp0.2 (MPa)	Rm (MPa)	A5 (%)	KV (J)
600	760	26	+20°C : 150

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon/Nitrogen : 3-6 l/min



ind.05