

ES TIG 2209

GTAW
ER2209

ESWECO
The Art of Welding

Description

Bare, corrosion-resistant, duplex welding rods for welding austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types.

ES TIG 2209 has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has high resistance to intergranular corrosion, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.

Current

DC (-)

Classifications

SFA/AWS A5.9	ER2209
EN 12072	W 22 9 3 NL

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	<0.5	1.7	22.5	8.5	3.3	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	600
Tensile strength, MPa	765
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
+20	100
-20	85
-60	60

Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0