

ES MIG 2209

GMAW
ER2209

ESWECO
The Art of Welding

Description

ES MIG 2209 a continuous, solid, corrosion-resistant, duplex wire for welding austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types.

ES MIG 2209 has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has a 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	G 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	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	3.4-11.0	50-140	16-22
1.0	2.9-8.4	80-190	16-22
1.2	4.9-8.5	180-280	20-28
1.6	2.3-5.5	230-350	24-28