

Classifications

AWS A5.9 / SFA-5.9	EN ISO 14343-A
ER 2209	W 22 9 3 N L

Characteristics and typical fields of application

Solid TIG rod of type ER2209 / W 22 9 3 N L is designed for welding 2205 duplex stainless steel. Resistant to intercrystalline corrosion and wet corrosion up to 475°F. Good resistance to stress corrosion cracking in chlorine and hydrogen sulfide bearing environment. High Cr and Mo-contents provide resistance to pitting corrosion. For joining and surfacing work with matching and similar duplex steels and cast steel grades. Attention must be paid to embrittlement susceptibility of the parent metal.

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	N
wt.-%	0.02	0.4	1.7	22.5	8.8	3.2	0.15

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy (ft.lbf)	
	ksi	ksi	%	68°F	-40°F
u	87 (65)	104 (80)	33 (20)	74	> 35

u untreated, as-welded

Operating data

	Dimension	Current A	Voltage V
	5/64" × 39"	100 – 130	14 – 16
	3/32" × 39"	130 – 160	16 – 18
	1/8" x 39"	160 - 190	18 - 20

Approvals

TÜV (03343), ABS, DNV GL, LR, NAKS, CE