

❖ Product Description

- I. A weld metal of composition 22.2% Cr, 9.5%Ni, & 0.15%N
- II. Spatter free, smooth arc
- III. Excellent and uniform weld beads
- IV. Increased tensile strength
- V. Good resistance to pitting

❖ Range of Application

- I. For welding duplex stainless steels material which increases the tensile strength

❖ Classification

- AWS/SFA 5.9 E2209

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Cu	Cr	Ni	Mo	N
E2209	Min	-	0.50	-	-	-	-	21.5	7.5	2.5	0.08
	Max	0.03	2.00	0.03	0.90	0.03	0.75	23.5	9.5	3.5	0.20

❖ Wire Size & Welding Position

- Diameter in mm- 1.60, 2.00, 2.40, 3.20, 4.00, 5.00.
- Weld Position- All position

❖ Packaging

- 25kg coil with or without support

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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