



# MIGINOX 2209

GMAW DUPLEX STAINLESS STEEL

AWS A/SFA 5.9 ER2209

### CLASSIFICATION:

EN ISO 14343-A  
G 22 9 3 N L

### KEY FEATURES:

- An extra low carbon 22Cr/9Ni/3Mo/N type duplex stainless steel wire
- Austenitic-ferritic type weld deposit
- Can be applied for operating temperature upto 200°C
- Excellent combination of high strength and resistance to chloride induced SCC and pitting
- Radiographic quality welds

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of 2205, 2209 type duplex stainless steels and similar grades
- Pipelines transporting chloride bearing products and sour gases
- Cladding on carbon and low alloy steels
- Cast pumps, Valve bodies and sea water handling equipment
- For chemical equipments, heat exchangers, off-shore platforms



### TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Ni	Mo	N
0.015	1.5	0.4	22.5	8.7	3.3	0.15

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	690 min	20 min

### PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	12.5	 <b>DCEP</b> <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	All Positions 
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
98Ar/2O <sub>2</sub> or Ar/1-5CO <sub>2</sub>	15-22