GMAW / GTAW DUPLEX STAINLESS STEEL

MIGINOX 2209 / TIGINOX 2209

DUPLEX STAINLESS STEEL ALLOY FOR HIGH STRENGTH AND PITTING RESISTANCE

CLASSIFICATION :	EN ISO 14343-A	AWS A/SFA 5.9	APPROVALS :
Miginox 2209:	G 22 9 3 N L	ER2209	-
Tiginox 2209:	W 22 9 3 N L	ER2209	-

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

WELDING POSITION :

GMAW: DCEP
GTAW: DCEN

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: 98Ar/2O_2 or Ar/1-5CO_2	15-22	10-20
GTAW: Ar	10-15	-

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

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	N	Cu	S	P
Specification	0.03 max	0.5-2.0	0.90 max	21.5-23.5	7.5-9.5	2.5-3.5	0.08-0.20	0.75 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

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

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

	Ø, mm		Kg/Spool	
Miginox 2209	0.8		12.5	
	1.2		12.5	
	1.6		12.5	
	2.0		12.5	
Tiginox 2209	**Ø x L, mm**	**Primary Box, Kg**	**No. of Primary Boxes**	**Net Wt. of Carton, Kg**
	2.4 x 1000	5	4	20
	3.2 x 1000	5	4	20

EQUIVALENT :

SMAW Electrode: **Betanox 4462**

FCAW Wire: **Miginox FC 2209**

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