

Filler rod and wire

| | |
|------------------------------|---|
| Features: | ▪ Suitable for normal duplex stainless steel (S32205, S31803, etc.) |
| Classification: | AWS A5.9 ER2209 |
| Shielding gas: | Ar or Ar-2%N ₂ |
| Identification color: | 1st Red, 2nd Green |
| Polarity: | DCEN |

Packaging data

| φ mm | Spool | | Tube | |
|------------------|------------------|----|-----------------|---------|
| | kg | kg | Length mm | g/piece |
| 1.2 | 10 | 5 | 1,000 | 9 |
| 1.6 | - | 5 | 1,000 | 16 |
| 2.0 | - | 5 | 1,000 | 25 |
| 2.4 | - | 5 | 1,000 | 36 |
| 3.2 | - | 5 | 1,000 | 64 |
| Volume mm | 240W, 110H, 240L | | 40W, 35H, 1015L | |

Composition (rod and wire mass%)

| | Typical | Guaranty ^a |
|-----------|---------|-----------------------|
| C | 0.01 | 0.03 |
| Si | 0.38 | 0.90 |
| Mn | 1.49 | 0.50~2.00 |
| P | 0.02 | 0.03 |
| S | <0.01 | 0.03 |
| Ni | 8.6 | 7.5~9.5 |
| Cr | 23.0 | 21.5~23.5 |
| Mo | 3.3 | 2.5~3.5 |
| Cu | 0.05 | 0.75 |
| N | 0.15 | 0.08~0.20 |

Welding parameters (A)

| φ mm | |
|------|---------|
| 1.2 | 50~100 |
| 1.6 | 100~200 |
| 2.0 | 100~200 |
| 2.4 | 150~250 |
| 3.2 | 200~300 |

Note: ^a Single values are maximum.

All-weld mechanical properties

| | Typical |
|---------------------|---------|
| 0.2%YS (MPa) | 615 |
| TS (MPa) | 814 |
| EI on 4d (%) | 38 |
| IV -50°C (J) | 150 |