

Exaton 2209LSi

2209Si is designed for gas shielded arc welding and particularly MIG welding of duplex stainless steels, such as Sandvik SAF 2205 and Sandvik SAF 2304. Its corrosion resistance is equal to ASTM 904L in most applications. It combines high strength with excellent ductility. 2209Si can also be used for joining Sandvik SAF 2205 or Sandvik SAF 2304 to carbon steel or low-alloy steels. It is used for TIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER2209 EN ISO 14343-A : W 22 9 3 N L EN ISO 14343-B : 2209
Approvals	CE EN 13479 VdTUV 10055

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic-ferritic (duplex) with approx. 55 FN ferrite - 22.5% Cr - 8% Ni - 3% Mo - Low C + Si
Shielding Gas	I1, I3, N2 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	200 J (148 ft-lb)
As Welded	-20 °C (-4 °F)	180 J (133 ft-lb)
As Welded	-46 °C (-51 °F)	155 J (115 ft-lb)
As Welded	-50 °C (-58 °F)	145 J (107 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.5	0.8	0.001	0.02	8.5	23	3.1	0.1	0.16

Typical Weld Metal Analysis %

Nb	W	PRE	FN WRC-92
0.01	0.01	35.8	54

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.012	1.5	0.8	0.0007	0.018	8.6	23	3.2	0.05	0.09

Typical Wire Composition %

N	Nb	Ti	Co	W	PRE	FN WRC-92
0.15	0.01	0.003	0.04	0.01	37	55