Exaton 2209LSi

2209LSi 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. 2209LSi can also be used for joining Sandvik SAF 2205 or Sandvik SAF 2304 to carbon steel or low-alloy steels. It is used for MIG/MAG welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER2209 EN ISO 14343-A : 22 9 3 N L EN ISO 14343-B : 2209
Approvals	CE EN 13479 VdTÜV 04620

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	M12, M13 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	110 J (81 ft-lb)
As Welded	-20 °C (-4 °F)	105 J (78 ft-lb)
As Welded	-46 °C (-51 °F)	95 J (70 ft-lb)
As Welded	-50 °C (-58 °F)	90 J (67 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

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm (0.030 in.)	40-120 A	15-19 V	4.0-8.0 m/min (157-315 in./min)
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)

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