

Exaton 2209

2209 is used for welding of duplex stainless steels such as Sandvik SAF 2205 and SAF 2304. It can also be used for welding of duplex stainless steels to carbon steel. 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	ABS ER 2209 BV ER 2209 CE EN 13479 DNV-GL Duplex Steels VdTUV 19480

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
Shielding Gas	I1, I2, 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	-40 °C (-40 °F)	160 J (118 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	0.5	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	0.5	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