

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 MIG/MAG welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER2209 EN ISO 14343-A : G 22 9 3 N L EN ISO 14343-B : 2209
Approvals	CE EN 13479 DNV-GL Stainless steel* VdTUV 19479

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	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	-40 °C (-40 °F)	100 J (74 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
0.014	1.5	0.45	0.001	0.017	8.5	23	3.0	0.09	0.15

Typical Weld Metal Analysis %

Nb	W	PRE	FN WRC-92
0.01	0.01	35.3	52

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

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)
1.6 mm (1/16 in.)	230-350 A	25-30 V	3.0-5.0 m/min (118-197 in./min)