

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