



TIG 2209



Standards

AWS 5.9
ER 2209

EN ISO 14343-A
W 22 9 3 N L

W. Nr.
1.4462

Description & applications

Filler metal in solid wire sticks for TIG welding of duplex stainless steels .
The duplex (austenitic-ferritic) structure provides an improved resistance to stress corrosion cracking, particularly in the presence of H₂, as well as a good overall corrosion resistance level.

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P Max	Fe
0.02	1.7	0.5	23.0	9.0	3.0	0.02	0.02	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV-196°C
750 MPa	600 MPa	25 %	40 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 I1 : 100 % Argon 6-12 l/mn Root : Argon, Nitrogen 3 -6 l/mn

