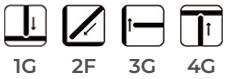
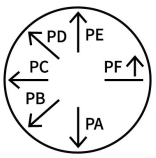
SW-2209 Cored

Classification

AWS AWS A5.22/ ASME SFA-5.22 E2209T1-1/-4
JIS Z 3323 TS2209-FB1
EN ISO 17633-A-T 22 9 3 N L P M21/C1 2

Welding Positions





Features

- Designed for welding with CO2 & Ar+CO2 mixed shielding gas.
- This wire is designed for Duplex stainless steels.
- Arc stability is excellent, so spatter loss is low and slag covering is uniform with good removability

Polarity

DC +

Application Areas

- Duplex stainless steel welding

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

ABS	BV	CCS	DNV	KR	LR	NK	RS	CE
✓	✓	✓	✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Ni	Cr	Mo
100% CO2	0.03	0.6	0.7	0.022	0.006	8.7	23.0	3.3
Ar+20~25% CO2	0.03	0.5	1.1	0.010	0.009	8.8	23.3	3.7

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	830(120)	29	-20(0) -50(-60)	45(33) 35(26)
Ar+20~25% CO2	840(121)	27	-20(0) -50(-60)	44(32) 35(26)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2(0.045)	160~220	Spool 20kg (44lbs)