

TIGINOX 2209 / MIGINOX 2209

Classification

AWS A/SFA 5.9 : ER 2209

Characteristic

A 22.5Cr, 8.5Ni, 3Mo, 0.15N stainless steel wire for TIG/MIG welding of Duplex stainless steel 22Cr type. These stainless steels are characterized by high tensile strength, resistance to stress corrosion cracking and improved resistance to pitting.

Typical Application

This wire is suitable for welding 22% Cr duplex stainless steels such as UNS S31803 and S32205, ASTM S51, proprietary alloys such as Hy Resist 22/5, SAF 2205 (Sandvik) etc. Used for pipe work and general fabrication in offshore, oil & gas, and chemical process industries.

Wire Chemistry

C	S	P	Mn	Si	Cr	Ni	Mo	N	Cu
0.03 max	0.03 max	0.03 max	0.50-2.0	0.90 max	21.5-23.5	7.5-9.5	2.5-3.5	0.08-0.20	0.75 max

Properties of weld metal with 100% Argon gas shielding Current Condition: TIG : DC (-) MIG : DC (+)

Classifications:

All Weld Mechanical Properties As welded condition

UTS MPa	690 min
Elongation % (L=4xd)	18-20

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Packing Specifications for MIGINOX 2209

Dia., mm	0.8	1.2	1.6	2.0
Net wt per spool,kg	12.5	12.5	12.5	12.5

Packing Data for TIGINOX 2209

Dia., mm	2.4	3.2
Length,mm	1000	1000
Net wt per tube,kg	5	5
No of Plastic Tubes per Box	4	4
Net wt,Box,kg	20	20



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