

PRODUCT DATA SHEET

TIG WIRE - PROWELD - 2209/ (1.4460)

Classification: AWS / ASME – A/ SFA 5.9 ER2209
BS EN 14343: 2009 – W22.9.3 N L

Approvals: TUV, CE Marking

Typical Applications:

Proweld 2209 is primarily used for welding duplex steel of similar composition. The weld metal gives a austenitic/ferritic weldment. The material offers the very good strength and resistance to stress corrosion and pitting.

Shielding Gas:

I1 Pure Argon 5-10 L/min
M13 Argon+1-3% O₂, 5-10 L/min

Corrosion resistance:

Good resistance to stress corrosion and cracking.
Also offers good resistance pitting corrosion.

Wire Composition: (%)

	C	Mn	Mo	Cr	Ni	S	P	N
min	-	0.5	2.50	21.5	7.5	-	-	0.08
max	0.03	2.0	3.50	23.5	9.5	0.02	0.03	0.20

Packaging Detail:

Diameter : 0.80,1.00,1.20,1.60, 2.0, 2.40,
3.20, 4.0 mm*
Length : 1000 mm (36")

Mechanical properties (Typical as Weld):

Tensile Strength	800N/mm ²
Yield Strength	600N/mm ²
Elongation A5	35%
Impact energy(20° C)	120J
-80C	40 J
Hardness	220BHN

Packing : 5 Kgs in Spiral Tubes/Plastic,
then in a Master Carton of 25
Kg(5x5)**

Also available in AWS standard diameters

Ferrite content:

Ferrite Number about 50 – WRC-92

Marking:

Both ends embossed with grade and diameter for
the diameter >=1.60mm

Welding Parameters:

The information will be provided on
request.