

GETIG 2209

IDENTIFICATION

Getig 2209, ER 2209

CLASSIFICATION

AWS/SFA 5.9: ER 2209, BS 2901: Pt2 22.8.3S92

DESCRIPTION

Solid duplex stainless wire for welding 2205 type duplex stainless steels.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
0.03 max	0.5-2.0	0.25 - 0.65	0.02 max	0.03 max	21.5 -23.5	7.5-9.5	2.5-3.5	0.5 max	0.14 - 0.20

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
710 - 900	28 - 35	-30°C	>140

TYPICAL APPLICATIONS

- Standard duplex stainless steels UNS S31803 (wrought) J92205 (cast), ASTM F51, DIN 1.4462, BS 1501 318S13.
- Proprietary alloys such as Hy-Resist 22/5 (Avesta Sheffield), SAF 2205 (Sandvik), AF22 (Mannesmann), Uranus 45N (Creusot).
- The wire is designed for TIG welding standard duplex stainless steels meeting the requirements of UNS S31803. It over-matches the parent material by 2-3% with respect to Ni to give the correct micro- structural balance of austenite & ferrite in the as-welded condition. Used for pipe-work & general fabrication in the off-shore oil & gas & chemical process industries.
- Duplex weld metal microstructure with austenite + 30 50% ferrite.
- Pitting resistance equivalent PRE = %Cr + 3.3 % Mo + 16% Ni is > 35

HARDNESS : 23 (<28) HRC

SHIELDING GAS : As recommended

BLACK PURGE : As recommended

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	500 / 1000	5	5 x 4 = 20
2.4	500 / 1000	5	5 x 4 = 20

GWELD

SEAL OF TRUST
2.5

500 / 1000	5	5 x 4 = 20	
3.15 / 3.20	500 / 1000	5	5 x 4 = 20