



MIG D22/09

Old reference: MIG 2209

Classification

ISO 14343-A : G 22 9 3 N L
 AWS A5.9 : ER2209

Material N° : ~1.4462

Description & Applications

Solid wire electrode with very low carbon content for joining Duplex stainless steels (austenitic-ferritic microstructure) .Resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion.

Main applications: For pumps, vessels, piping systems etc. attacked by chloride containing solutions. But also for impellers and other components which require high strength combined with corrosion attack.

Base materials:

UNS	Alloy	EN 10088	Material N°	CLI
S31803		X2CrNiMoN22-5-3	1.4462	URANUS 45N
S32304	35N	X2CrNi23-4	1.4362	URANUS 35N
S32900	329	X3CrNiMoN27-5-2	1.4460	

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N ₂	P	S	Fe
0.012	0.5	1.75	23.0	8.8	3.2	0.1	0.14	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	KV (J)	FN
600	800	28	+20°C 140	-40°C 70	~40

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	100-150	22-27	Ar+20%He+0.05% CO ₂ Ar + 2%CO ₂ Ar + 1%O ₂ 18-20 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	
	1.6	180-260	24-30	

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