



TIG D22/09

Old reference: TIG 2209

Classification

ISO 14343-A : W 22 9 3 NL
 AWS A5.9 : ER2209

Material N° : 1.4462

Description & Applications

Very low carbon content solid rod for TIG welding Duplex 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	N ₂	P	S	Fe
0.012	0.5	1.7	23.0	8.8	3.2	0.14	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
600	760	26	+20°C	150
			-50°C	120

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

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