



SELECTARC UP 2209

SAW Wire Electrode

Classification

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

Material N° : 1.4462

Characteristics

Solid wire for submerged arc welding with an austenitic- ferritic micro structure (duplex). The weld metal can be applied for operation temperatures up to 250°C and is resistant in chloride containing media, like sea water, against pitting corrosion as well as crevice and stress corrosion.

Applications

Butt welding and cladding of steels with an austenitic - ferritic structure, which are used for Pumps, Vessels, Piping systems etc. attacked by chloride containing solutions. But also for other components which require high strength combined with corrosion attack.

Base Materials

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

Typical Wire Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	P	S	Fe
0.014	0.50	1.50	22.90	8.60	3.0	0.08	0.15	0.012	0.005	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (KV)	
	R _m (MPa)	R _{p0.2} (MPa)	A ₅	Temp.°C	J
AW	800	630	26	- 30	90
				- 60	65

Welding Current & Instructions

Process	Ø (mm)	Welding Parameters			Flux
		Current (A)	Voltage (V)	Speed cm/mim	
SAW = +	2.4	340 - 380	28 - 29	48 - 60	UP WP 380
	2.8	360 - 430	28 - 29	48 - 60	UP WP 380M
	3.2	450 - 550	28 - 29	48 - 60	UP Inox L

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