



## EWB<sup>®</sup> – ER 2209 MIG / TIG Welding Wires

### Classifications:

EN ISO 14343-A:2007 : G 22 9 3 N L  
EN ISO 14343-B:2007 : SS 2209  
AWS A5.9: ER2209

Material No. ~1.4462

### Typical Chemistry Composition of Weld Deposit:

C	Cr	Ni	Mo	Mn	Si
<0.03	21.50 – 23.50	7.50 – 9.50	2.50 – 3.50	0.50 – 2.00	<0.90

### Description:

- MIG / TIG welding of 22%Cr-9%Ni-3%Mo duplex stainless steels (UNS S310803, STS 329J1, 329J2L)

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
min. 450	min. 690	min. 20

### Welding Parameters:

Wire Diameter (Ø in mm)	0.80	1.00	1.20
Pulsed Arc (A)	100 - 150	120 - 200	140 - 220
Voltage (V)	22 - 27	24 - 28	24 - 28

### Packing Available:-

**MIG/MAG Wire** (Ø in mm): 0.80 / 1.00 / 1.20

**TIG Wire** (Ø in mm): 1.60 / 2.40 / 3.20 / 4.00

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### EWB Weld

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