KT-2209

Classification

AWS A5.9/A5.9M ER2209

Applications and Features

(1) Weld metal is duplex stainless steel with 22.5%Cr-8.5%Ni-3%Mo-0.15%N.

(2) Higher strength and excellent resistance to pitting and stress corrosion cracking.

(3) It is suitable for welding duplex stainless steel with 22% Cr, such as UNS S31803 (Alloy 2205).

Typical Chemical Composition (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.015	0.43	1.55	0.009	0.007	21.85	9.51	3.01	0.14

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar)

Tensile Strength MPa	Yield Strength MPa	Elongation %
810	615	28

Sizes and Suggested Operating Range

Size mm	Current A	Gas Flow L/min	Shielding Gas
1.6	75- 100	25	Ar
24	150-200	25	Ar