

OK Tigrod 2209

Bare corrosion resisting Duplex welding rods for welding of austenitic-ferritic stainless alloys of 22% Cr 5% Ni 3% Mo types. OK Tigrod 2209 has a high general corrosion resistance. In media containing chloride and hydrogen sulphide the alloy has a high resistance to intergranular, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.

Specifications	
Classifications	EN ISO 14343-A : W 22 9 3 N L SFA/AWS A5.9 : ER2209
Approvals	CE : EN 13479 DB : 1.2-3.2mm DNV-GL : 2.0-4.0mm NAKS/HAKC : 1.6-3.2 mm UKCA : EN 13479 VdTÜV : 1.2-3.2mm

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic-ferritic (22.5 % Cr - 8 % Ni - 3 % Mo - Low C)
Shielding Gas	I1, I2, I3, N2 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
0.5 hour(s) 1050 °C (1922 °F)	450 MPa (65 ksi)	730 MPa (106 ksi)	34 %
As Welded	600 MPa (87 ksi)	765 MPa (111 ksi)	28 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	130 J (96 ft-lb)
-20 °C (-4 °F)	110 J (81 ft-lb)
-60 °C (-76 °F)	90 J (66 ft-lb)
20 °C (68 °F)	100 J (74 ft-lb)
-10 °C (14 °F)	
-20 °C (-76 °F)	85 J (63 ft-lb)
-60 °C (-76 °F)	60 J (44 ft-lb)

Typical Wire Composition %								
C	Mn	Si	Ni	Cr	Mo	N	PRE	FN WRC-92
0.01	1.5	0.5	8.5	22.7	3.2	0.17	35	55