

Exaton 2209

2209 is a duplex stainless filler metal for welding duplex stainless steels. Weldability as well as properties of the all-weld metal is excellent. Corrosion resistance is equal to 904L in most applications. 2209 is used for welding of duplex stainless steels such as 2205 and 2304. It can also be used for welding of duplex stainless steels to carbon steel and for cladding. It is used for Submerged Arc Welding.

Specifications

Classifications	EN ISO 14343-A : S 22 9 3 N L SFA/AWS A5.9 : ER2209
Approvals	CE : EN 13479 UKCA : EN 13479

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)
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Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.012	1.5	0.5	0.0007	0.018	8.6	23	3.2	0.05	0.09

Typical Wire Composition %

N	Nb	Ti	Co	PRE	FN WRC-92	W
0.15	0.01	0.003	0.04	37	55	0.01