

Meltolit

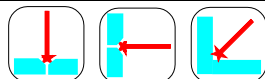
Duplex 2209 XT

AWS A 5.9: ER2209 ISO 14343-A: W 22 9 3 N L

DESCRIPTION

Stainless steel wire for welding wrought, forged or cast duplex stainless steels for service in the as-welded condition. Heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels.

WELDING POSITIONS



CURRENT

DC-

GAS

Ar (I1)

BASE MATERIAL

1.4462, 1.4362, 1.4062, 1.4162

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
780	600	26	+20°C – 150 -50°C – 100

WELD METAL COMPOSITION(%)

C	Si	Mn	Ni	Cr	Mo	N
0,01	0,5	1,5	8,6	22,5	3,3	0,17

PACKAGING AND WELDING PARAMETERS

Dimension(mm)	1,0	1,2	1,6	2,0	2,4
Box(kg)	5	5	5	5	5

EQUIVALENT FILLER METALS

MMA	Meltolit Duplex 2209 E
MIG	Meltolit Duplex 2209 XM
FCW	Meltolit Duplex 2209 FCW /FCW-PW