

MIGWELD 2209

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 22 9 3 NL DIN 8556 : SG-X2 CrNiMoN22 9 3 AWS A-5.9 : ER 2209 W.Nr. : 1.4462		Power generation industry Petrochemical and chemical industry Shipbuilding&Offshore

- High-alloyed welding wire for welding duplex steels.
- High resistance to intergranular corrosion, pitting and stress corrosion cracking.
- Used in all industries for welding and plating to obtain a corrosion resistant coating.

Application

Filler material mainly for duplex type 2205. Used for general production pipelines in the offshore oil and gas industry and in the chemical industry. Suitable for steel plating. Paper machines, lye tanks, digesters for pulp and paper, cellulose fermenters, bleaching washers, pre-steaming vessels. Pressure vessels, pollution control equipment, Pipelines, heat exchangers for transporting gas and oil. Impellers, fans, shafts and press rolls requiring combined strength and corrosion resistance. Cargo tanks for ships and trucks, biofuel plants. Sea water cooler pipes, pulverized coal gasification coolers. In the production of urea: working pump body, pump valves, shut-off valves and all other elements most exposed to damage.

Base material

EN	W.Nr.	AISI/ASME/INNE
X2CrNiMoN 22 5 3	1.4462	2205 / S31803, S32205
X2CrNiMoSi19 5	1.4417	301LN / S31500
X3CrNiMoN 27 5 2	1.4460	329 / S32900
X2CrNiN 23 4	1.4362	S32304 / S32304
		S32404
For dissimilar connections between non-alloy and low-alloy steels to duplex steels		
1.4462 X2CrNiMoN 22 5 3 with 1.4583 X10CrNiMoNb 18 12		
1.4462 X2CrNiMoN 22 5 3 with P235GH, P265GH, S255N, P295GH, S430N, 16Mo3, UNS S31803, S322005		
		/J92205
		//UR45N, UR45N+/UR35N
		//NK Cr22 (Nippon Kokan)
X10CrNiMoNb10 12	1.4162	S32101
X4CrNiMoN27 5 2	1.4460	329 / S32900
X10CrNiMoNb10 12	1.4583	318/
G-X8 CrNi26 7	1.4347	
X4 CrNiMoNb25 7	1.4582	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	N
0,025	0,50	1,60	23,00	9,00	3,00	0,14

Typical mechanical properties

Yield strength Re [N/mm2]	>560
Tensile strength Rm [N/mm2]	>730
Elongation A5 [%]	>26
Impact energy Kv [J]	>37J (-60°C) /
Wire/rod type	solid
Welding current	
Welding positions	
Additional description	Structure Austenite + Ferrite
Shielding gases acc. to EN ISO 14175	I1 - Ar / M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	50-140	16-22	15,0
1,0	80-190	16-24	15,0
1,2	180-280	20-28	15,0

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