



Changzhou Sanzhong Welding Materials Co.,Ltd

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Standard: AWS A 5.9 YB/T5092	Chemical Composition %								
	C	Mn	Si	Cr	Ni	P	S	Mo	N
Grade ER2209	≤0.03	0.5 – 2.0	≤ 0.90	21.5 – 23.5	7.5 – 9.5	≤0.03	≤0.03	≤0.75	0.08 – 0.2
Type	Spool (MIG)				Tube (TIG)				
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0				1.6、2.0、2.4、3.2、4.0、5.0				
Package	S100/1kg S270,S300/15kg-20kg			S200/5kg		5kg/box	10kg/box	length :1000MM	
Diameter (MM)	0.8	1.0	1.2	1.6	2.0	2.5	3.2		
Current (A)	70 ~ 150	100 ~ 200	140 ~ 220	50 ~ 100	100 ~ 200	200 ~ 300	300 ~ 400		
Application	<p>ER2209 is also called H03Cr22Ni8Mo3N.The main composition is 22Cr-9Ni-3Mo-N. it is an austenitic ferrite dual phase stainless steel MIG wire. Full-position welding. Because the deposited metal contains about 40% ferrite, the deposited metal has both the comprehensive properties of austenitic stainless steel and the stress corrosion resistance of ferrite stainless steel. Thus it has become a new material in petrochemical industry. It has excellent welding workability, such as smooth wire feeding, stable arc, beautiful shape and few spatter.</p> <p>It is often used in petrochemical, shipbuilding and other industries, corresponding to the welding of steel 022Cr22Ni5Mo3N (SUS2205). Also suitable for 22Cr-9Ni-Mo3 duplex stainless steel such as UNS31803.</p>								
Notice	<ol style="list-style-type: none"> 1. Oil, dirt and rust on the welding wire surface should be removed before welding. Surface impurities such as oil, rust and water should be thoroughly removed in the welding place, so as to prevent blowhole, crack and so on during welding. The surface of the groove and its surroundings should be polished with metallic gloss. 2. In order to obtain good mechanical properties of welding seam, suggest protect gas Ar+2%O2 and shield gas flow rate 20-25 L/min for MIG welding. For TIG welding,suggest protect gas pure Ar and shield gas flow rate 8-15 L/min ,Arc length 1~3 mm; Length of the tungsten pole is about 3~5 mm; wind speed limit ≤ 1.0 m/s, argon protection at the back of welding area . 3. In the welding process, the welding line energy directly affects the mechanical properties and crack resistance of weld metal, and should be paid more attention to. 4. The above welding methods, conditions and specifications are for reference only. Users should evaluate the welding process according to their own welding characteristics before using the welding wire for the formal product welding. 								



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