

## Description

A continuous, solid, corrosion-resistant, duplex wire for welding austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types.

OK Autrod 2209 has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has a high resistance to intergranular corrosion, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.

## Welding current

DC(+)

## Classifications

SFA/AWS A5.9	ER2209
EN 12072	G 22 9 3 NL

## Typical chemical composition, aw (%)

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.7	22.5	8.5	3.3	<0.3

## Typical mech. properties all weld metal

Yield stress, MPa	600
Tensile strength, MPa	765
Elongation, %	28

## Charpy V

Test temps, °C	Impact values, J
+20	100
-20	85
-60	60

## Approvals

DNV	For duplex stainless steels
GL	4462S
RINA	Restricted availability
Sepros	UNA 485179
UDT	DIN 8556
VdTÜV	

## Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	3.4-11.0	50-140	16-22	0.8-2.6
1.0	2.9-8.4	80-190	16-24	1.0-3.2
1.2	4.9-8.5	180-280	20-28	2.6-4.6
1.6	3.2-5.5	230-350	24-28	3.0-5.2