

## Description

Bare, corrosion-resistant, duplex welding rods for welding austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types.

OK Tigrod 2209 has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has 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	W 22 9 3 NL

## Wire composition

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

Sepros	UNA 485179
UDT	DIN 8556
VdTÜV	

## Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.2	1000	5.0
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0