

CODIFICATION: AWS/SFA 5.9: ER2209

CHARACTERISTICS AND APPLICATIONS:

FW 2209 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. Deposits have duplex microstructures consisting of an austenite – ferrite matrix, which is characterized by high tensile strength, resistance to stress corrosion cracking, and improved resistance to pitting. It is used primarily to weld duplex stainless steels, which contain approximately 22 percent Cr such as UNS S31803 and S32205.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	N
Percent	0.020	1.30	0.30	0.020	0.020	22.5	8.5	3.0	0.12

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d) %
720	25.0

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITION : H, F, VU, OH

PACKING:

STANDARD SIZE	Diameter 1.6 mm, 2.0 mm, 2.5 mm & 3.2 mm in cut lengths of 1000 mm each.
QUANTITY	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire.

An ISO 9001: 2008 certified company

D & H Sécheron Electrodes Pvt. Ltd.

44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260
e-mail: info@dnhsecheron.net Website: www.dnhsecheron.com

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