

T-2209

For austenite stainless steel (Low carbon, 22%Cr-9%Ni-Mo STS)

Classifications

EN ISO 14343-A:2009	: W 22 9 3 N L
EN ISO 14343-B:2009	: SS 2209
AWS A5.9-2012	: ER2209
JIS Z 3321:2008	: YS2209

Approvals – I1 (100% Ar)

ABS	: ER2209
BV	: 2205
DNV	: ER2209
LR	: S31803 m
KR	: RY 31803
NK	: KY2209
RS	: AF-8dup

Description

- TIG welding of 22%Cr-9%Ni-3%Mo duplex stainless steels (UNS S31893, STS 329J1,329J2L)
- Various applications of petrochemical offshore structure and distilling apparatuses

Polarity & shielding gas

- DCEN (DC-)
- Ar: 100% Ar (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr	Mo
0.01	0.40	1.67	8.7	22.70	3.10

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	-10 °C	-50 °C
AWS A5.9		Min. 690	Min. 20		
EN ISO 14343	Min. 450	Min. 550	Min. 20		
Example	769	855	32	183	160