

Stainless solid wire

Classification

AWS A5.9	: ER2209
EN 12072	: W 22 9 3 N L / G 22 9 3 N L

General description

Solid wire for welding duplex stainless steels
High resistance to general corrosion, pitting and stress corrosion

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO ₂
GMAW	M13	Mixed gas Ar+ >0-3% O ₂

Approvals

	BV	GL	TÜV
GTAW			+
GMAW	2209	4462S	+

Chemical composition (w%), typical wire / rod

C	Mn	Si	Cr	Ni	Mo	N
0.018	1.5	0.5	22.7	8.5	3.0	0.15

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)			
							+20°C	-20°C	-46°C	-60°C
Typical values	GTAW	I1	AW	600	800	28	85	60		45
	GMAW	M12	AW	625	810	28	110	40		

Materials to be welded

Steel grades	En 10088-1/-2	W.Nr.	ASTM/ACI A240	UNS
Duplex stainless steels	X2 CrNiMoN 22 5 3	1.4462		S31803
		1.4417		S31500
	X3 CrNiN 23-4	1.4362		S32304
		1.4460		S31200

Dissimilar joints such as un- and low alloyed steel to duplex stainless steel

Packaging and available sizes

Process	Unit	Diameter (mm)	0.8	1.0	1.2	1.6	2.0	2.4	3.2
GTAW	2 and 10 kg tube					X	X	X	X
GMAW	15 kg spool BS300		X	X	X	X			

Other sizes and packaging on request

LNT/LNM 4462: rev. EN 20

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request