

## Filler rod and wire

<b>Features:</b>	▪ Suitable for normal duplex stainless steel (S32205, S31803, etc.)
<b>Classification:</b>	AWS A5.9 ER2209
<b>Shielding gas:</b>	Ar or Ar-2%N <sub>2</sub>
<b>Identification color:</b>	1st Red, 2nd Green
<b>Polarity:</b>	DCEN

## Packaging data

φ mm	Spool	Tube		
	kg	kg	Length mm	g/piece
1.2	10	5	1,000	9
1.6	-	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
<b>Volume mm</b>	240W, 110H, 240L	40W, 35H, 1015L		

## Composition (rod and wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.01	0.03
<b>Si</b>	0.38	0.90
<b>Mn</b>	1.49	0.50~2.00
<b>P</b>	0.02	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	8.6	7.5~9.5
<b>Cr</b>	23.0	21.5~23.5
<b>Mo</b>	3.3	2.5~3.5
<b>Cu</b>	0.05	0.75
<b>N</b>	0.15	0.08~0.20

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

## All-weld mechanical properties

	Typical
<b>0.2%YS (MPa)</b>	615
<b>TS (MPa)</b>	814
<b>EI on 4d (%)</b>	38
<b>IV -50°C (J)</b>	150