



Kjellberg Finsterwalde Elektroden und Maschinen GmbH, Germany

Product Data Sheet

SUPERTIG 2209

SS TIG WELDING WIRE
Stainless and Heat resistant steels

Classification :

AWS A 5.9 : ER 2209
EN 14343 - A : W 22 9 3 NL

Description: SUPERTIG 2209 is a W 22 9 3 NL/ ER 2209 type solid TIG welding rod depositing a low C 22Cr 8Ni 3Mo weld metal. Suitable for use mainly with Ar shielding gas. SUPERTIG 2209 is used for the welding of duplex stainless steels in a range of applications including the Fabrication of pipe and plate.

The weld metal provides a high resistance to pitting and stress corrosion cracking especially in high chloride media. The weld metal nickel content over matches the parent material by 2-3% to provide an optimum balance of austenite and ferrite in the as welded condition.

Materials to be welded

1.4462 (X2CrNiMoN22-5-3)
UNS S31803 - S31500 - S31200 - S32304.

Shielding Gas

EN ISO 14175 : I1

Typical Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P	N2
0.030 max	0.50-2.00	0.90 Max	21.50-23.50	7.50-9.50	2.50-3.50.	0.50 max.	0.03 max.	0.03 max.	0.08-0.20

Typical All Weld Mechanical Properties

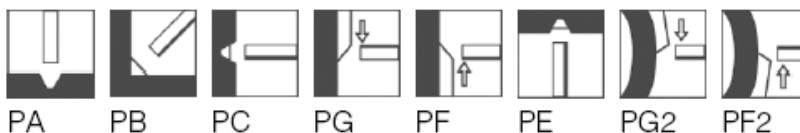
Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO-V(J) 20° C
≥ 480	≥ 690	≥ 22	≥ 50

Corrosion Resistance :- Corresponding to ER 2209 i.e. fairly good under severe conditions such as oxidising and cold dilute reducing acids .

Current Conditions: - DC (-)

Storage: - Keep dry and avoid condensation.

Welding Position:-



Packing Data

Size(mm) DxL	1.20 x 1000	1.60 x 1000	2.00 x 1000	2.40 x 1000	3.20 x 1000	4.00 x 1000
Net wt. per tube(kg)	5	5	5	5	5	5
Net wt. per Box(kg)	20	20	20	20	20	20