OK Tigrod 2209

Bare corrosion resisting Duplex welding rods for welding of austenitic-ferritic stainless alloys of 22% Cr 5% Ni 3% Mo types. OK Tigrod 2209 has a high general corrosion resistance. In media containing chloride and hydrogen sulphide the alloy has a high resistance to intergranular, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.

Specifications	
Classifications	EN ISO 14343-A : W 22 9 3 N L SFA/AWS A5.9 : ER2209
Approvals	CE : EN 13479 DB : 43.039.19 NAKS/HAKC : 2.0MM-3.2MM VdTÜV

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic-ferritic (22.5 % Cr - 8 % Ni - 3 % Mo - Low C)
Shielding Gas	I1, I2, I3, N2 (EN ISO 14175)

Typical Tensile Properties				
Condition	**Conditional Statement**	**Yield Strength**	**Tensile Strength**	**Elongation**
Stress Relieved	SHT 1050°C 0.5h	450 MPa	730 MPa	34 %
As Welded	As welded	600 MPa	765 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
Stress Relieved	20 °C	130 J
Stress Relieved	-20 °C	110 J
Stress Relieved	-60 °C	90 J
As Welded	20 °C	100 J
As Welded	-20 °C	85 J
As Welded	-60 °C	60 J

Typical Wire Composition %								
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**PRE**	**FN WRC-92**
0.01	1.5	0.5	8.5	22.7	3.2	0.17	35	55