

SW-2209 Cored

Type : Rutile

Conformances

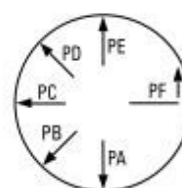
AWS A5.22/ ASME SFA5.22 E2209T1-1/-4
JIS Z3323 TS2209-FB1
EN ISO 17633-A-T 22 9 3 N L M21/C1 2
KR AWS A5.22 E2209T1-1
ABS AWS A5.22 E2209T1-1(-46°C)
LR S31803

BV UP (KV -20°C ≥41 J)
DNV-GL Duplex Stainless Steel (M21)
NK KW2209G(C)
RS AF-8dup (M21)

Applications

- Duplex stainless steel (NAS 329J3L, UNS S31803)

Welding Position



Features

- Good performance in all positions

Current

DC +

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo	N	PREN
100% CO ₂	0.03	0.60	0.7	0.022	0.006	23.0	8.7	3.3	0.13	36
80% Ar + 20% CO ₂	0.03	0.50	1.1	0.010	0.009	23.3	8.8	3.7	0.11	37.5

Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
100% CO ₂	830 (120,350)	29.0	-20 (-4) -50 (-58)	45 (33.2) 35 (25.8)
80% Ar + 20% CO ₂	840 (121,800)	27.0	-20 (-4) -50 (-58)	44 (32.4) 35 (25.8)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO ₂	20 (4/5)	6.5 (256)	140	23-26	2.6 (5.7)
		9.8 (386)	180	27-30	3.8 (8.4)
		12.5 (492)	210	28-31	4.9 (10.8)
80% Ar + 20% CO ₂	20 (4/5)	6.5 (256)	140	23-26	2.8 (6.2)
		9.5 (374)	180	27-30	4.0 (8.8)
		12.0 (472)	210	27-30	5.0 (11.0)

Diam.	15 kg Spool
1.2mm	HKSW220912

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