

KM-2209

Classification

Shielding Gas:	Ar+1~2%O ₂	AWS A5.9/A5.9M	ER2209
	Ar+1~2%CO ₂	AS/NZS ISO 14343	B SS2209

Applications and Features

- (1) Weld metal is duplex stainless steel with 22.5%Cr-8.5%Ni-3%Mo-0.15%N.
- (2) Higher strength and excellent resistance to pitting and stress corrosion cracking.
- (3) It is suitable for welding duplex stainless steel with 22% Cr, such as UNS S31803 (Alloy 2205).

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current, spray transfer welding .
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.015	0.43	1.55	0.009	0.007	22.71	8.52	3.01	0.15

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2% O₂)

Tensile Strength MPa	Yield Strength MPa	Elongation %
810	620	28

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)		
		0.9	1.0	1.2
Ar+1~2%CO ₂	Amp	60~140	80~160	100~210
	Volt	15~21	16~22	17~22
Ar+1~2%O ₂	Amp	170~260	180~280	200~300
	Volt	24~30	24~30	24~30

Diam.	15 kg Spool
0.9mm	KM22090915
1.0mm	KM22091015
1.2mm	KM22091215

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