

# MI 2209

Gazaltı (MIG/MAG) Kaynak Teli - Stainless Steels

### Standards

AWS/ASME SFA - 5.9	ER2209
EN ISO 14343 - A	G 22 9 3 N L
TS EN ISO 14343 - A	G 22 9 3 N L
DIN M. No.	~1.4462

### Properties and Applications

Dublex (ferritic-austenitic) stainless steel wire electrode for GMA (MIG/MAG) welding of duplex Cr-Ni-Mo stainless steels. Especially used in welding of acid tanks and pipes, in chemical, petrochemical, paper, shipbuilding and desalination industries. Suitable also for welding duplex stainless steels to carbon steels. The high strength and ductile weld metal exhibits good resistance to pitting, crevice corrosion and stress corrosion cracking in chloride-bearing media. Suitable for operating temperatures up to 250°C.

### Materials

Width	Material
X2CrNiMoN 22-5-3	1.4462
X10CrNiMoNb18-12	1.4583

### Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Mo	N
Welding Wire	0.01	0,50	1.50	23.50	8.50	3.50	0.15

### Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	M13	580	770	30	-40°C → 90

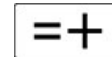
\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M13 (Ar+%0,5-3 O2) .

### Application Information

#### Welding Positions



#### Polarity:



#### Protection Gas:

M13 M12 M14 I1

#### Welding Parameters & Efficiency

Diameter (mm)
1.00
1.20

### Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23012DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23012EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

### Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.