SI 2209

Submerged Arc Welding Wire - Stainless Steels

Standards

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

Properties and Applications

Dublex (ferritic-austenitic) stainless steel wire electrode for submerged arc welding of dublex Cr-Ni-Mo stainless steels. Used in combination with SIF 501 and SIF 502 submerged arc welding fluxes. Especially used in welding of acid tanks and pipes, in chemical, petrochemical, paper, shipbuilding and desalination industries. Suitable also for dissimilar welding of dublex stainless steels to carbon steels. High-strength and ductile weld metal exhibits good resistance to pitting, crevice corrosion and stress corrosion cracking in chloride-bearing media.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Mo	N
Welding Wire	0.02	0.60	1.60	22.50	8.50	3.00	0.15

Typical Chemical Values of Weld Metal

Welding Flux	Type of Analysis	C	Si	Mn	Cr	Ni	Mo	N
SIF 502	Weld Deposit	0.02	0.75	1.10	22.50	8.50	2.50	0.12
SIF 501	Weld Deposit	0.02	0.45	1.70	22.00	8.00	2.50	0.10

Typical Mechanical Values of Weld Metal

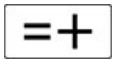
Test Condition	Welding Flux	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	SIF 502	590	760	28	20°C → 55	-60°C → 35
As welded	SIF 501	600	770	31	20°C → 80	-60°C → 55

Application Information

Welding Positions

PA PB

Polarity:



Welding Parameters & Efficiency

Diameter (mm)
3.20

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
43005LXAM2	3.20	25 kg	25.90	1	25.90	Wire Basket Spool (K435)

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.