



Nevatia Steel & Alloys Pvt. Ltd.
Office : 904,Lodha Supremus,9th floor
Worli, Mumbai ,India - 400018.
Web:<http://www.nevatiasteel.com>



TD-Stainless Welding wire
Revision No.: 02
Date of Issue : 01.11.2019

IATF 16949 , ISO 9001, ISO 14000 and ISO 45001 Certified
Company

Stainless steel welding wire -Technical data

Product Name : nevinox[®]MIG2209

Product Specifications : ER 2209

Grade	Equivalent Standards		
	AWS A5.9/5.9M	EN ISO 14343 A	EN ISO 14343 B
ER 2209	ER 2209	22 9 3 N L	2209

Characteristics : ER2209 is intended to weld duplex stainless steels. Exhibits high tensile strength and resistance to stress and corrosion cracking.

Application : ER 2209 is used for the welding of duplex stainless steels in a range of applications including the fabrication of pipe and plate. The weld metal provides a high resistance to pitting and stress corrosion cracking especially in high chloride media. The nickel is over matches the parent material by 2-3% to provide an optimum balance of austenite and ferrite in the as welded condition.

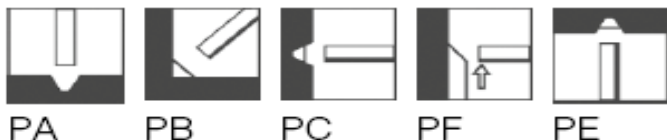
Chemical Composition % (Solid wire)

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	N
0.03	1.20 - 2.00	0.030	0.020	0.20 - 0.90	21.50 - 23.50	7.50 - 9.50	2.50 - 3.50	0.50	0.10 - 0.20

Remarks: Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

Current Conditions:- DC (+)

Welding position: -





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Dimension & Packing Data

Size(mm)	Size(inch)	SD100 Spool packing 1kg/2lb	SD200Spool packing 5kg/10lb	SD300/BS300 Spool packing 12.5kg,15kg /25lb, 33lb	Drum packing 100kg,250kg/ 200lb, -550 lb
0.600	0.024	√	√	-	-
0.800	0.030	√	√	√	√
0.900	0.035	√	√	√	√
1.000	0.040	√	√	√	√
1.200	0.045	√	√	√	√
1.600	0.063	-	√	√	√

Diameter tolerance and ovality

- As per AWS A5.9 and ISO 544

Inspection & certification

- As per EN 10204 type 3.1

For more details please contact : sales@nevatiasteel.com.