



Nevatia Steel & Alloys Pvt. Ltd.  
Office : 904,Lodha Supremus,9<sup>th</sup> 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®TIG2209

**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 :** ER 2209 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.

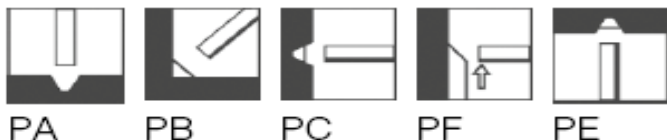
### Chemical Composition % (Solid wire)

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: -**



PA PB PC PF PE



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### Dimension & Packing Data

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Tube packing 5 kg/10lb	Box packing 20/25 kg / 50 lb
0.90	0.035	1000	36"	√	√
1.00	0.040	1000	36"	√	√
1.20	0.045	1000	36"	√	√
1.60	1/ 16"	1000	36"	√	√
2.00	5/ 64"	1000	36"	√	√
2.40/2.50	3/ 32"	1000	36"	√	√
3.15/3.20	1/ 8"	1000	36"	√	√
4.00	5/ 32"	1000	36"	√	√
5.00	3/ 16"	1000	36"	√	√

### 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](mailto:sales@nevatiasteel.com).