

PRODUCT DATA SHEET

MIG WIRE - PROWELD - 2209/ (1.4460)

Classification: AWS / ASME – A/ SFA 5.9 ER2209
BS EN 14343: 2009 – G22.9.3 N L

Approvals : TUV , CE Marking

Typical Applications:

Proweld 2209 is primarily used for welding duplex steel of similar composition. The weld metal gives austenitic/ferritic weldment. The material offers the very good strength and resistance to stress corrosion and pitting.

The welding parameters such as Current, Voltage, and Welding Speed depend on applications, section thickness etc for each wire size. This information will be provided on request.

Wire Composition: (%)

	C	Mn	Mo	Cr	Ni	S	P	N
min	-	0.5	2.50	21.5	7.5	-	-	0.08
max	0.03	2.0	3.50	23.5	9.5	0.03	0.03	0.20

Shielding Gas:

M12 Argon+2% CO₂, 14-20 L/min
M13 Argon+1-3% O₂, 14-20 L/min

Corrosion resistance:

Good resistance to stress corrosion and cracking. Also offers good resistance pitting corrosion.

Mechanical properties (Typical as Weld):

Tensile Strength	800N/mm ²
Yield Strength	600N/mm ²
Elongation A5	35%
Impact energy(20° C)	120J
-80C	40 J
Hardness	220BHN

Packaging Detail:

Diameter : 0.80, 1.00, 1.20 , 1.60 mm *

Packing ** : 12.5Kg (25 lbs), 15Kg (30 – 33lbs)
Layer wound plastic spools i.e. SD300, Metallic basket (K300).
5Kg (10lbs) layer wound plastic spools i.e. SD200.
1Kg (2lbs) layer wound plastic spools i.e. SD100.
Drum pack 100 kgs and 250 kgs (0.80, 1.00, 1.20mm)

*Also available in AWS standard diameters.

Ferrite content:

Ferrite Number about 50 – WRC-92

Welding Parameters:

Diameter (mm/in.)	Current (A)	Voltage (V)
0.80 / 0.030"	100-160	18-22
1.00 / 0.040"	140-200	18-24
1.20 / 0.045"	170-260	20-28
1.60 / 0.060"	220-350	24-36