

DW-2209

All positional flux cored wire for duplex stainless



Code Data

AWS A5.22 E2209T1-1, 4

Outstanding Features

- All heats contain high nitrogen content for higher strength and better corrosion resistance.
- High impact properties can be guaranteed even at -40°F (-40°C).
- DW-2209 has the option of being shielded by 75%Ar-25%CO₂ gas mixture or 100%CO₂ gas (75%Ar-25%CO₂ recommended).
- DW-2209 provides a smooth bead appearance, minimal spattering and slag is easily removability.

Typical chemistry of weld metal (75%Ar-25%CO₂)

C	Si	Mn	Cr	Ni	Mo	Cu	N	PRE	FN
0.024	0.55	0.89	22.96	9.68	3.28	0.06	0.14	36.0	40.5

PRE=Cr+3.3×Mo+16×N, FN=Ferrite Number by WRC Diagram(1992)

Typical mechanical property of weld metal (75%Ar-25%CO₂)

0.2%P.S (psi)	T.S (psi)	Elongation (%)	Impact value (ft-lbs)	
			-40 °F	0 °F
89,490	117,200	31	44 <28.1>	54 <41.9>

Test method: AWS A5.22, welding parameter: 200A-28V (0.045")

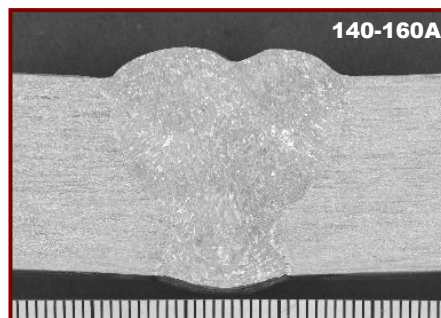
< >: Lateral expansion (unit=mils)

Pitting Corrosion Property

Test condition	Corrosion loss (g/m ² ·hr)	Judgment
68°F × 24hr	0.005	No Pitting
77°F × 24hr	0.032	No Pitting

Test method: According ASTM G48A

Macrostructure of butt joint (3G)



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warning.ca.gov.

July 2018