ALLOY DESCRIPTION AND APPLICATION;
2209T-1 duplex stainless steel flux cored electrodes are used to weld 22% chromium duplex stainless steel such as 2205, 2209, 2304 and other proprietary duplex stainless steels. It has a smooth running arc that deposits very high tensile strength, with resistance to stress, corrosion, cracking and pitting... 2209 may also be a good choice when welding Duplex stainless such as 2553 to carbon steels or other grades of stainless.

TYPICAL WELDING PROCEDURES; DCEP

<table>
<thead>
<tr>
<th>Wire Diameter</th>
<th>Wire Speed (ipm)</th>
<th>Amps</th>
<th>Volts</th>
<th>Electrical Stickout</th>
<th>CO₂ (cfh)</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.045</td>
<td>215-450</td>
<td>140-220</td>
<td>25-30</td>
<td>1/2-1”</td>
<td>35-50</td>
</tr>
<tr>
<td>1/16”</td>
<td>175-315</td>
<td>190-310</td>
<td>28-31</td>
<td>5/8-1”</td>
<td>35-50</td>
</tr>
</tbody>
</table>

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

<table>
<thead>
<tr>
<th>Element</th>
<th>%</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carbon</td>
<td>0.04</td>
</tr>
<tr>
<td>Manganese</td>
<td>0.50-2.0</td>
</tr>
<tr>
<td>Silicon</td>
<td>1.00</td>
</tr>
<tr>
<td>Chromium</td>
<td>21.0-24.0</td>
</tr>
<tr>
<td>Nickel</td>
<td>7.50-10.0</td>
</tr>
<tr>
<td>Molybdenum</td>
<td>2.50-4.00</td>
</tr>
<tr>
<td>Phosphorus</td>
<td>0.04</td>
</tr>
<tr>
<td>Sulfur</td>
<td>0.03</td>
</tr>
<tr>
<td>Nitrogen</td>
<td>0.08-0.20</td>
</tr>
<tr>
<td>Copper</td>
<td>0.50</td>
</tr>
<tr>
<td>Elongation</td>
<td>20%</td>
</tr>
<tr>
<td>Tensile Strength (psi)</td>
<td>100,000</td>
</tr>
</tbody>
</table>

Iron balance and all single values are maximum percentages.

AVAILABLE SIZES: TSF 2209T-1 = .045, 1/16”
Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.22 E2209T0-1
ASME SFA 5.22 E2209T0-1
ASME F - 6

EAST COAST | GULF COAST | WEST COAST
---|---|---
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