

## Stainless solid wire

### Classification

AWS A5.9-93	: ER2209
EN 12072-99	: W 22 9 3 N L / G 22 9 3 N L

### General description

**Solid wire for welding duplex stainless steels**  
**High resistance to general corrosion, pitting and stress corrosion**

### Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO <sub>2</sub>
GMAW	M13	Mixed gas Ar+ >0-3% O <sub>2</sub>

### Approvals

	BV	CTL	GL	TÜV
GTAW		+		+
GMAW	2209	+	4462S	+

### Chemical composition (w%), typical, wire / rod

C	Mn	Si	Cr	Ni	Mo	N
0.018	1.5	0.5	22.7	8.5	3.0	0.15

### Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)		
							+20°C	-20°C	-46°C
Typical values	GTAW	I1	AW	600	800	28	85	60	45
	GMAW	M12	AW	625	810	28	110	40	

### Materials to be welded

Steel grades	En 10088-1/-2	W.Nr.	ASTM/ACI A240	UNS
Duplex stainless steels	X2 CrNiMoN 22 5 3	1.4462		S31803
		1.4417		S31500
	X3 CrNiN 23-4	1.4362		S32304
		X3 CrNiMoN 27-5-2	1.4460	

Dissimilar joints such as un- and low alloyed steel to duplex stainless steel

### Packaging

Process	Unit	Sizes (mm)							
		0.8	1.0	1.2	1.6	2.0	2.4	3.2	
GTAW	2 and 10 kg tube					X	X	X	X
GMAW	15 kg spool BS300	X	X	X	X				

Other sizes and packaging on request

LNT/LNM 4462: rev. EN 15