OK Autrod 2209

A continuous solid corrosion resisting duplex wire for welding of austenitic-ferritic stainless alloys of 22% Cr, 5% Ni, 3% Mo types. OK Autrod 2209 has a high general corrosion resistance. In media containing chloride and hydrogen sulphide the alloy has a high resistance to intergranular, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.

Classifications Wire Electrode:	EN ISO 14343-A:G 22 9 3 N L, SFA/AWS A5.9:ER2209
Approvals:	CE EN 13479, VdTÜV 05387, NAKS/HAKC 1.2MM, DB 43.039.18, DNV For duplex stainless steels* (M13), GL 4462S* (M13), VdTÜV 13039*

**Valid for lot numbers starting with PV. Approvals are based on factory location. Please contact ESAB for more information.*

Alloy Type:	Austenitic-ferritic (22.5 % Cr - 8 % Ni - 3 % Mo - Low C)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS 98 Ar/2 O2 (M13)			
As welded	590 MPa	785 MPa	31 %
EN 98 Ar/2 O2 (M13)			
As welded	610 MPa	785 MPa	32 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS 98 Ar/2 O2 (M13)		
As welded	-30 °C	105 J
As welded	-46 °C	90 J
EN 98 Ar/2 O2 (M13)		
As welded	-30 °C	95 J
As welded	-46 °C	90 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N
0.01	1.5	0.5	8.5	22.7	3.2	0.17

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	50-140 A	16-22 V	3,4-11 m/min	0,8-2,7 kg/h
1.0 mm	80-190 A	16-24 V	2,9-8,4 m/min	1,1-3,1 kg/h
1.2 mm	180-280 A	20-28 V	4,9-8,5 m/min	2,6-4,5 kg/h
1.6 mm	230-350 A	24-28 V	3,2-5,5 m/min	3-5,2 kg/h