

## OK Tigrod 2209

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

<b>Classifications Wire Electrode:</b>	SFA/AWS A5.9:ER2209, EN ISO 14343-A:W 22 9 3 N L
<b>Approvals:</b>	CE EN 13479, VdTÜV 05519, VdTÜV 06282, NAKS/HAKC 2.0MM-3.2MM, DB 43.039.19, VdTÜV 13010

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type:</b>	Austenitic-ferritic (22.5 % Cr - 8 % Ni - 3 % Mo - Low C)
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As welded	600 MPa	765 MPa	28 %
SHT 1050°C 0.5h	450 MPa	730 MPa	34 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As welded	20 °C	100 J
As welded	-20 °C	85 J
As welded	-60 °C	60 J
SHT 1050°C 0.5h	20 °C	130 J
SHT 1050°C 0.5h	-20 °C	110 J
SHT 1050°C 0.5h	-60 °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