



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 2209

Prepared by Daniel Amahatsion	Qualified by Tero Borg	Approved by Jay A Coubrough	Reg no EN006935	Cancelling EN006754	Reg date 2015-11-27	Page 1 (2)
----------------------------------	---------------------------	--------------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

TÜV and DB Approval Added

GENERAL

Bare corrosion resisting Duplex welding rods for welding of austenitic-ferritic stainless alloys of 22% Cr 5% Ni 3% Mo types.

OK Tigrod 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.

Shielding Gas: I1, I2, I3 (EN ISO 14175)

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

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A W 22 9 3 N L
SFA/AWS A5.9 ER2209

APPROVALS

CE EN 13479
DB 43.039.19
VdTÜV 13010

APPROVALS (SPECIFIC)

VdTÜV 05519 Only for lot numbers starting with IT
VdTÜV 06282 Only for lot numbers starting with FP

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C		0.025
Si	0.30	0.70
Mn	1.20	1.85
P		0.020
S		0.020
Cr	21.5	23.5
Ni	8.0	9.0
Mo	3.00	3.40
Co		0.25
Nb		0.10
Cu		0.30
Al		0.020
N	0.14	0.190
Others tot		0.50



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 2209

Prepared by Daniel Amahatsion	Qualified by Tero Borg	Approved by Jay A Coubrough	Reg no EN006935	Cancelling EN006754	Reg date 2015-11-27	Page 2 (2)
----------------------------------	---------------------------	--------------------------------	--------------------	------------------------	------------------------	---------------

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	SHT 1050°C 0.5h	As welded	
	Typ	Min	Typ
Rp0.2 (MPa)	450	480	600
Rm (MPa)	730	680	765
A4-A5 (%)	34	25	28
Charpy V at 20°C (J)	130	40	100
Charpy V at -10°C (J)		32	
Charpy V at -20°C (J)	110		85
Charpy V at -60°C (J)	90		60

OTHER DATA

Welding should proceed with neither too high or too low heat input (general recommendation 0.5-2.5 kJ/mm).