



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
13**

WI-0304 DS174A NDS-2209R, Rev. 0, Date 01.05.2011

NDS-2209R	TIG WELDING ROD FOR WELDING 22% Cr DUPLEX STAINLESS STEELS					DATA SHEET NO. 174A						
	SPECIFICATION		AWS A5.9			BS EN 12072						
CLASSIFICATION		ER2209			W 22 9 3 N L							
WELD METAL ANALYSIS COMPOSITION % BY Wt.			C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
		MIN.	-	21.5	7.5	2.5	0.5	-	-	-	0.08	-
		MAX.	0.03	23.5	9.5	3.5	2.0	0.9	0.03	0.03	0.2	0.75
		TYPICAL	0.01	22.5	8.5	3.1	1.6	0.4	0.02	0.01	0.15	0.1
WELD METAL PROPERTIES (AS WELDED)		<u>PROPERTY</u>		<u>UNITS</u>	<u>MIN.</u>	<u>TYPICAL</u>	<u>OTHERS</u>					
		Tensile strength		N/mm ²	690	810						
		0.2% Proof stress		N/mm ²	450	620						
		Elongation on 4d		%	20	30						
		Impact energy -20°C		J		160						
OTHER DATA		Argon mainly use as shielding gas										
RELATED PRODUCTS		Please contact our Technical Department for detail.										