

Classifications							
EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	Mat. No.				
G 22 9 3 N L	SS2209	ER2209	≈1.4462				
Characteristics and typical fields of application							
Duplex stainless steel; resistant to intercrystalline corrosion and wet corrosion up to 250 °C (482 °F). Good resistance to stress corrosion cracking in chlorine- and hydrogen sulphide-bearing environment. High Cr- and Mo-contents provide resistance to pitting corrosion. For joining and surfacing work with matching and similar austenitic steels / cast steel grades. Attention must be paid to embrittlement susceptibility of the parent metal.							
Base materials							
TÜV-certified duplex stainless steels 1.4462 – X2CrNiMoN22-5-3 and others, also combinations of aforementioned steels and ferritic steels up to S355J, 16Mo3 and 1.4583 – X10CrNiMoNb18-12 – UNS S31803, S32205							
Typical analysis of solid wire (wt.-%)							
	C	Si	Mn	Cr	Mo	Ni	N
wt-%	0.025	0.5	1.6	23.0	3.0	9.0	0.14
Structure: Austenite/Ferrite							
Mechanical properties of all-weld metal							
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	MPa	%	+20 °C		
aw	510	550	700	25	70		
Operating data							
Polarity: DC (+)	Shielding gas: (EN ISO 14175) M12, M13	ø (mm) 0.8 1.0 1.2	Spool: BS300 B300 B300				
Welding instruction							
Materials	Preheating	Postweld heat treatment					
Matching / similar steels / cast steel grades	None	Mostly none; if necessary solution annealing at 1050 °C (1922 °F)/ water					
Approvals							
TÜV (03342), DB (43.132.36) DNV, GL, CE							