

Standards

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|-------------------|----------------|
| TS EN ISO 14343-A | : W 22 9 3 N L |
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| AWS A5.9 | : ER 2209 |

**Chemical Composition of
Welding Wire % (Typical)**

| C | Si | Mn | Cr | Ni | Mo | N |
|------|------|------|-------|------|------|------|
| 0.02 | 0.40 | 1.70 | 22.80 | 7.80 | 2.90 | 0.15 |

Mechanical Properties

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Elongation (L ₀ =5d ₀) (%) | Impact Strength (ISO-V/-46°C) |
|--|--|--|----------------------------------|
| 550 | 700 | 28 | 100 J |

Typical Base Material Grades

- SAE 2209, SAE 2205, EN14462, X2CrNiMoN22-5-3, X2CrNiN23-4, X2CrNiMoN22-5-3 with X10CrNiMoNb18- 12 and X2CrNiMoN22-5-3 with P235GH/ P265GH, S255N, P295GH, S355N and 16Mo3 combinations, UNS S31803, S32205.

Features and Applications

- GeKa ELOX SG 2209 is duplex stainless steel TIG Welding rod contains low Carbon and approximate %22Cr, %9Ni and %3Mo
- Microstructure is Austenite + Ferritic
- The weld metal has an excellent resistance to stress corrosion, cracking and pitting
- The use of this welding rod, pipe and general manufacturing industries, offshore applications, oil, gas, chemical and petrochemical industry
- Shielding gas: TIG; pure Ar or Ar+%1-2N₂ mix gases can be used

Welding Positions

Current Type

MIG D.C. (+) / TIG D.C. (-)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Weight (Kg) | Package Type |
|--------------|------------------------------------|------------|----------------|--------------|
| 6011100308 | 1,2 | 0.047" | 15 | BS 300 |
| 6011100309 | 2.00 x 1000 | 5/64 x 39" | 5 | Plastic Box |
| 6011100310 | 2.40 x 1000 | 3/32 x 39" | 5 | Plastic Box |

Approvals: CE