

❖ Product Description

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| I. An extra low carbon 22Cr/9Ni/3Mo/N type steel wire | III. Resistant to corrosion, erosion, pitting and impact |
| II. Austenitic ferritic type weld deposit | IV. The operating is smooth |
| | V. Radiographic weld quality |

❖ Range of Application

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| I. For welding ASTM 6NM casting or similar grades as well as light gauges | III. Can be applied for operating temperature upto 200°C |
| II. Surfacing of turbine blades and high pressure valves | IV. Radiographic quality weld |

❖ Classification

- AWS/SFA 5.9 ER2209

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni	N
ER2209	Min	-	0.50	-	-	21.5	-	2.5	-	7.5	0.08
	Max	0.03	2.00	0.03	0.9	23.5	0.75	3.5	0.03	9.5	0.20

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	690	-	20	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60									
Packing Code	A	B	C	D	E	F	G	H	I	
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack	
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG	

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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