

❖ Product Description

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| I. The wire is used to overlay mild and low alloy steels | III. It has smooth operating characteristics |
| II. It is recommended to maintain preheat temperature 150°C or greater | IV. Radiographic weld quality |

❖ Range of Application

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| I. Used primarily to weld wrought material of similar composition | III. Valve bodies |
| II. Turbine, power generation | IV. High pressure piping, offshore welding |

❖ Classification

- AWS/SFA 5.9 ER 2209

❖ Chemical Composition

Type of Wire		C	Mn	Mo	Si	S	P	Cr	Ni	N	Cu
ER 2209	Min	-	0.50	2.5	-	-	-	21.5	7.5	0.08	-
	Max	0.03	2.00	3.5	0.90	0.03	0.03	23.5	9.5	0.20	0.75

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0, 2.40,3.20,4.00 and 5.00.
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

- (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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