

OK Tigrod 2209

Bare corrosion resisting Duplex welding rods for welding of austenitic-ferritic stainless alloys of 22% Cr 5% Ni 3% Mo types. OK Tigrod 2209 has a high general corrosion resistance. In media containing chloride and hydrogen sulphide the alloy has a high resistance to intergranular, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.

Specifications	
Classifications	EN ISO 14343-A : W 22 9 3 N L SFA/AWS A5.9 : ER2209
Approvals	CE : EN 13479 DB : 1.2-3.2mm DNV-GL : 2.0-4.0mm UKCA : EN 13479 VdTÜV : 1.2-3.2mm

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic-ferritic (22.5 % Cr - 8 % Ni - 3 % Mo - Low C)
Shielding Gas	I1, I2, I3, N2 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	597 MPa (87 ksi)	786 MPa (114 ksi)	29 %
EN ISO			
As Welded	600 MPa (87 ksi)	765 MPa (111 ksi)	28 %
SHT 0.5 hour(s) 1050 °C (1922 °F)	450 MPa (65 ksi)	730 MPa (106 ksi)	34 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	130 J (96 ft-lb)
20 °C (68 °F)	100 J (74 ft-lb)
-10 °C (14 °F)	
-20 °C (-4 °F)	110 J (81 ft-lb)
-20 °C (-76 °F)	85 J (63 ft-lb)
-60 °C (-76 °F)	90 J (66 ft-lb)
-60 °C (-76 °F)	60 J (44 ft-lb)

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.5	0.5	0.002	0.015	8.5	22.7	3.2	0.1	0.17

Typical Wire Composition %	
PRE	FN WRC-92
35	55