

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	786 MPa	29 %
EN ISO			
As Welded	600 MPa	765 MPa	28 %
SHT 0.5 hour(s) 1050 °C	450 MPa	730 MPa	34 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	-60 °C	69 J
EN ISO		
As Welded	20 °C	100 J
SHT 0.5 hour(s) 1050 °C	20 °C	130 J
As Welded	-20 °C	85 J
SHT 0.5 hour(s) 1050 °C	-20 °C	110 J
As Welded	-60 °C	60 J
SHT 0.5 hour(s) 1050 °C	-60 °C	90 J

Typical Wire Composition %								
C	Mn	Si	Ni	Cr	Mo	N	PRE	FN WRC-92
0.01	1.5	0.5	8.5	22.7	3.2	0.17	35	55