

# M-2209

**AWS ER2209**

**FOR STAINLESS STEEL**

## Typical applications

Welding of 23%Cr-9%Ni-3%Mo stainless steels (UNS S31803, STS 329J1/329J2L) A various applications of chemical engineering, shipbuilding and nuclear plant industries etc.

## Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr	Mo
0.01	0.40	1.75	8.70	22.70	3.20

## Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	IV (J)
Ar+2%O <sub>2</sub>	840 {86}	28	-46°C:110 -196°C:50

## Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by