

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.

Classifications Wire Electrode	SFA/AWS A5.9 : ER2209 EN ISO 14343-A : W 22 9 3 N L
Approvals	CE EN 13479 DB 43.039.19 DNV-GL Duplex Steels NAKS/HAKC 1.6-3.2 mm VdTUV 13010

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
SHT (1050°C 0.5h)	450 MPa	730 MPa	34 %
As Welded	600 MPa	765 MPa	28 %

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