



SWASTIK-WELD

JINIK MARKETING

Swastik Weld Make Welding Wire GMAW/GTAW (MIG & TIG) for Duplex & Super Duplex Steel

I) ER 2209 CLASSIFICATION: AWS A/SFA 5.9

Chemical Composition of ER 2209 Wire:

Si= 11.0-13.0

C= 0.03 max

Mn= 0.05-2.0

Si= 0.90 max

Cr= 21.5-23.5

Ni= 7.5-9.5

Mo= 2.5-3.5

N= 0.08-0.20

Cu= 0.75 max

S= 0.03 max

P= 0.03 max



Mechanical Properties of All Weld

Metal:

UTS, Mpa= 690 min

EL%= 20

TYPICAL APPLICATION OF ER 2209 WIRE (Duplex Wire)

- 1) An extra low carbon 22Cr/9Ni/3Mo/N type duplex stainless steel wire for welding of 2205, 2209 type duplex stainless steels and similar grades
- 2) Pipelines transporting chloride bearing products and sour gases
- 3) Cladding on carbon and low alloy steels
- 4) Cast pumps, Valve bodies and sea water handling equipment
- 5) For Chemical equipments, heat exchangers, off-shore platforms

Packing: Tig: In cut length of 1000mm in 5kgs boxes (size: 1.6, 2.0, 2.40, 3.15mm) Mig: Continuous wire in 12.5kgs / 15kgs Plastic Spool (size: 0.80, 1.2mm)

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