



# S. R. Industries

## STAR ARC ER2209

**ER2209** filler metal is designed to weld duplex stainless steels such as UNS Number N31803. The welds are characterized by high tensile strength and improved resistance to stress corrosion cracking and pitting. The wire is lower in ferrite compared to that of base metal in order to obtain improved weldability.

**AWS Specification :** AWS A5.9/A5.9M:2006

|                                                      |               |
|------------------------------------------------------|---------------|
| <b>AWS Classification</b>                            | <b>ER2209</b> |
| <b>Welding Current</b>                               | <b>DCEP</b>   |
| <b>Typical Wire Chemistry</b>                        |               |
| <i>C</i>                                             | 0.03          |
| <i>Cr</i>                                            | 21.5 - 23.5   |
| <i>Ni</i>                                            | 7.5 - 9.5     |
| <i>Mo</i>                                            | 2.5 - 3.5     |
| <i>Mn</i>                                            | 0.50 - 2.00   |
| <i>Si</i>                                            | 0.90          |
| <i>P</i>                                             | 0.03          |
| <i>S</i>                                             | 0.03          |
| <i>N</i>                                             | 0.08 - 0.20   |
| <i>Cu</i>                                            | 0.75          |
| <b>Typical Mechanical Properties<br/>(As Welded)</b> |               |
| <b>Yield Strength, ksi</b>                           | 93            |
| <b>Tensile strength, ksi</b>                         | 108           |
| <b>Elongation%, min</b>                              | 42            |

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| <i>Welding Positions</i>                                    | <i>F,V,OH,H</i>  |
|-------------------------------------------------------------|------------------|
| <i>Available Diameters MIG with Operating Range in Amps</i> |                  |
| <i>.030"</i>                                                | <i>50 - 100</i>  |
| <i>.035"</i>                                                | <i>160 - 210</i> |
| <i>.045"</i>                                                | <i>180 - 250</i> |
| <i>Available Diameters TIG with Operating Range in Amps</i> |                  |
| <i>.035"</i>                                                | <i>60 - 90</i>   |
| <i>.045"</i>                                                | <i>80 - 110</i>  |
| <i>1/16"</i>                                                | <i>90 - 130</i>  |
| <i>3/32"</i>                                                | <i>120 - 175</i> |
| <i>1/8"</i>                                                 | <i>150 - 220</i> |
| <i>5/32"</i>                                                | <i>170 - 350</i> |

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