



Duplex Solid Wire

MIG/TIG Welding

AWS A5.9: ER2209
EN ISO 14343 2009 22 9 3 N L

SW-4462

DESCRIPTION & APPLICATION

MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition (Duplex). The analysis of the wire is overmatched with respect to the base material to ensure the correct microstructure when welded. Used in the fabrication of plate and pipework in the petro-chemical and offshore industry.

BASE MATERIALS

UNS 31803, J92205, Werkstoffe No. 1.4462
Hy-resist 22/5, Avesta 2205, Sandvik 2205, 2304
Creusot Uranus 45N

MECHANICAL PROPERTIES

~780 UTS n/mm	>580 YIELD 0.2%	>30 ELONG A5%	>120 (ISO-V) IMPACT (J) -50°C
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Cu	Fe
0.015	0.35	1.52	22.8	8.5	3	0.01	0.01	0.1	BAL

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

Shielding gas MIG 5% or 20% CO₂ in Argon, 2% Argon-Ox or proprietary special gas.
TIG 100% Argon. Do not allow the base material to overheat, maintain interpass temperature below 150°C.

Need Help?

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