

# Product Data Sheet



**BRAND NAME** VJ ER2209

**AWS/ASME Class** ER2209

**SPECIFICATION** SFA A5.9

## Features and Applications :

VJ ER2209 is specifically designed for welding duplex stainless steels, such as UNS S31803 and S32205. It offers high tensile strength, excellent resistance to stress corrosion cracking, and a controlled low ferrite content.

## CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.20	Mn	1.40
Cr	22.50	Si	0.45
Ni	8.50	S	0.015
Mo	2.50	P	0.015
Cu	0.75	N	0.15

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As weld	
Properties	Typical
UTS (MPa)	720
El (%)	26

## DIMENSIONS:

Dimension (mm)	
GMAW	GTAW
0.80	1.6
1.20	2.0
1.60	2.4
	3.2

<b>GMAW CURRENT</b> : DC (+)	<b>SHIELDING GAS:</b> ARGON
<b>GTAW CURRENT</b> : DCEN	<b>SHIELDING GAS:</b> ARGON

## PACKING :

**GTAW** : 5 kg wire put in a plastic container. Identification AWS code is punched on side of wire.

**GMAW** :The wire can be supplied in plastic spool packed in a cardboard box weighing 15.0 kg.

## WELDING POSITION:

