

DESCRIPTION

Executive 2209 wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire. Corrosion-resistant electrode for the welding of austenitic-ferritic duplex stainless steels.

Executive 2209 is a filler metal designed to weld duplex stainless steels which contain approximately 22 percent chromium. These alloys have "duplex" microstructures consisting of an austenite-ferrite matrix.

Executive 2209 wire is lower in ferrite compared to that of the base metal in order to obtain improved weldability.

APPLICATIONS & FEATURES

Executive 2209 welds are characterized by high tensile strength and improved resistance to stress corrosion cracking and pitting.

Executive 2209 is commonly used in offshore, oil and gas, petrochemical, chemical and other applications with a grade 2205 base.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
0.02	23.10	8.60	3.30	1.46	0.41	0.020	0.001	0.06	0.17

Tensile Strength:	105,000 PSI min	Yield Strength:	87,000 PSI min	Elongation:	32.2%
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TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar	
	.045"	22-23	180-210			
	.062"	23-24	200-220			
	- Spray	.035"	23-25			190-260
		.045"	25-28			250-330
		.062"	28-31			310-350
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER2209**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.

