



PRODUCT INFORMATION

SIFSTEEL STAINLESS DUPLEX

EN ISO 14343-B: 2209 (W 22 9 3 NL)
AWS A5.9: ER 2209

DESCRIPTION

A solid, bare duplex stainless steel TIG filler rod, for welding austenitic-ferritic alloys where a high resistance to intergranular corrosion, stress corrosion and pitting is required.

WELDING POSITIONS



Sifsteel Stainless Duplex is designed to be used to weld parent material of a similar composition, and is common in sour applications where exposure to corrosive chlorides and hydrogen sulphides can occur.

TYPICAL WELD METAL COMPOSITION

C	0.02 %
Si	0.5 %
Mn	1.7 %
Ni	8.5 %
Cr	22.5 %
Mo	3.3 %

TYPICAL MECHANICAL PROPERTIES

Melting Point	1440 °C
Ult Tensile Strength	765 N/mm ²
Hardness	240

MATERIAL TO BE WELDED

Duplex is a material that is increasing in popularity for its strength-to-weight ratio, price stability and corrosion-resistant properties. It is used for sheet and pipe applications, in a wide range of industry sectors, including petrochemical, chemical/pharmaceutical, pulp & paper, mining and food & beverage.

AVAILABLE FORMATS

1M ROD (TIG / GTAW)			
Dia			5.0 kg
1.0mm			RT741050
1.2mm			RT741250
1.6mm			RT741650
2.4mm			RT742450
3.2mm			RT743250

WELDING CURRENT		
Wire size	Amps	Tungsten, Thoriated
1.0	40-110	1.2 mm
1.2	60-130	1.6 mm
1.6	80-150	1.6 mm
2.4	150-260	2.4 mm
3.2	210-390	3.2 mm

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@weldability-sif.com**



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