

Exaton 2209LSi

2209LSi is designed for gas shielded arc welding and particularly MIG welding of duplex stainless steels, such as Sandvik SAF 2205 and Sandvik SAF 2304. Its corrosion resistance is equal to ASTM 904L in most applications. It combines high strength with excellent ductility. 2209LSi can also be used for joining Sandvik SAF 2205 or Sandvik SAF 2304 to carbon steel or low-alloy steels. It is used for MIG/MAG welding.

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|---------------------------------------|---|
| Classifications Wire Electrode | SFA/AWS A5.9 : ER2209 EN ISO 14343-A : 22 9 3 N L EN ISO 14343-B : 2209 |
| Approvals | CE EN 13479 VdTUV 04620 |

Approvals are based on factory location. Please contact ESAB for more information.

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|----------------------|---|
| Alloy Type | Austenitic-ferritic (duplex) with approx. 55 FN ferrite - 22.5% Cr - 8% Ni - 3% Mo - Low C + Si |
| Shielding Gas | M12, M13 (EN ISO 14175) |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------|---------------------|------------------|
| As Welded | 20 °C (68 °F) | 110 J (81 ft-lb) |
| As Welded | -20 °C (-4 °F) | 105 J (78 ft-lb) |
| As Welded | -46 °C (-51 °F) | 95 J (70 ft-lb) |
| As Welded | -50 °C (-58 °F) | 90 J (67 ft-lb) |

Typical Weld Metal Analysis %

| C | Mn | Si | S | P | Ni | Cr | Mo | Cu | N |
|------|-----|-----|-------|------|-----|----|-----|-----|------|
| 0.01 | 1.5 | 0.8 | 0.001 | 0.02 | 8.5 | 23 | 3.1 | 0.1 | 0.16 |

Typical Weld Metal Analysis %

| Nb | W | PRE | FN WRC-92 |
|------|------|------|-----------|
| 0.01 | 0.01 | 35.8 | 54 |

Typical Wire Composition %

| C | Mn | Si | S | P | Ni | Cr | Mo | V | Cu |
|-------|-----|-----|--------|-------|-----|----|-----|------|------|
| 0.012 | 1.5 | 0.8 | 0.0007 | 0.018 | 8.6 | 23 | 3.2 | 0.05 | 0.09 |

Typical Wire Composition %

| N | Nb | Ti | Co | W | PRE | FN WRC-92 |
|------|------|-------|------|------|-----|-----------|
| 0.15 | 0.01 | 0.003 | 0.04 | 0.01 | 37 | 55 |

Recommended Welding Parameters

| Wire Diameter | Current | Voltage | Wire Feed Speed |
|-----------------------|-----------|---------|-------------------------------------|
| 0.8 mm (0.030 in.) | 40-120 A | 15-19 V | 4.0-8.0 m/min (157-315 in./min) |
| 1.0 mm (0.040 in.) | 60-220 A | 15-28 V | 4.0-12.0 m/min (157-472 in./min) |
| 1.2 mm (0.047 in.) | 150-260 A | 24-29 V | 3.0-10.0 m/min (118-394 in./min) |