

LKT-2209

LKM-2209



LINKWELD ALLOYS INC.

AWS

A5.9 ER2209

Characteristics:

It is design for welding duplex stainless steel such as 2205. With good resistance to intergranular corrosion, pitting and stress corrosion cracking especially in environments containing H₂S and chlorides.

Applications:

It is suitable for welding of 22%Cr duplex stainless steel such as LUS31803.

Notes on Usage:

1. For TIG process, use DC(-) current .
2. For MIG process, use DC(+) current.
3. 98%Argon – 2%O₂ shielding gas is recommended in MIG process.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	Cr	Ni	Mo	N	Cu
0.01	1.66	0.41	22.6	8.70	3.18	0.151	0.12

Typical mechanical properties of weld metal

TS N/mm ²	EL %
745	27

Sizes available

MIG Solid Wire(mm)	0.8	0.9	1.0	1.2
TIG Rods(mm)	1.6	2.0	2.4	3.2