



# DAIKOSTRIP 2209

SAW - ESW

DUPLEX - SUPERDUPLEX

2209

## PRODUCT DESCRIPTION

**Strip electrode used to obtain a 2209 overlay weld deposit on carbon, carbon-manganese and low-alloy steels.**

It is used for weld surfacing of components in the chemical, petrochemical, marine industries where corrosion resistance on level with the duplex stainless steel UNS S31803 or UNS S32205 is required. Typical components are pressure vessels, heat exchangers, shafts, industrial piping etc. Good resistance to stress corrosion cracking. The resistance to intergranular corrosion is good.

## SPECIFICATIONS

AWS A5.9	EQ2209
EN ISO 14343-A	B 22 9 3 N L
DIN	-
Approvals	-
Shielding	DAIKOFLUX 930, 937AS

## ASME IX QUALIFICATION

F-No (QW432)	6
A-No (QW442)	-

## FERRITE

% 25-50

## PREN

36

## HARDNESS

-

## Chemical composition (nominal)

Chemical composition (nominal) 96

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.020	0.5	1.6	0.020	0.015	23.0	9.0	3.1	0.15

## Chemical composition of overlay

Typical chemical composition of overlay in three layers obtained on C-Mn steel and low-alloy steel.

Chemical composition, DAIKOFUX930	C	Cr	Ni	Mo	N	FN, WRC
3rd layer	<0,03	22-23,5	7,5-8,5	2,8-3,3	0,15-0,20	35-55

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