

MIG/MAG solid wires-TIG rods Stainless and Heat resistant steels

INERTFIL 22 9 3 is a G 22 9 3 N L / ER 2209 type solid MAG welding wire, supplied precision layer wound, depositing a low C-22Cr8Ni3Mo weld metal. Suitable for use with Ar+2%O₂ or Ar+0.5...5%CO₂ mixed shielding gases.

INERTFIL 22 9 3 is used for the welding of duplex stainless steels in a range of applications including the fabrication of pipe and plate.

The weld metal has a PREN value >35 giving a high resistance to pitting and stress corrosion cracking especially in high chloride media. The nickel is over matches the parent material by 2-3% to provide an optimum balance of austenite and ferrite in the as welded condition.

Classification

EN ISO	14343-A:G 22 9 3 N L
AWS	A5.9: ER 2209

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	N	Ferrite
0.020	1.7	0.5	≤ 0.025	≤ 0.020	23	9	3	0.15	30-65

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-40 °C
As Welded	≥480	≥690	≥ 22	≥50	≥32

Gas test: 81% Ar + 18% He + 1% CO₂

Shielding Gas - EN ISO 14175 : M12, M13

Materials

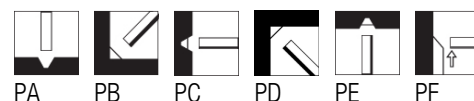
UNS S31803 - S31500 - S31200 - S32304
1.4462 (X2CrNiMoN22-5-3)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
0.8	●
1.0	●
1.2	●