

## TIG Rods Stainless and Heat resistant steels

INERTROD 22 9 3 is a W 22 9 3 N L / ER 2209 type solid TIG welding rod depositing a low C 22Cr 8Ni 3Mo weld metal. Suitable for use mainly with Ar shielding gas.

INERTROD 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 weld metal nickel content 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: W 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: 100% Ar

**Shielding Gas** - EN ISO 14175 : I1

### Materials

1.4462 (X2CrNiMoN22-5-3)

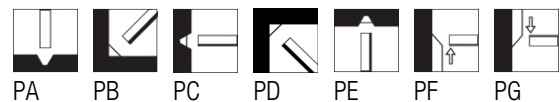
UNS S31803 - S31500 - S31200 - S32304

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



### Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.0	TUB	5	●
2.4	TUB	5	●