

# Inweld 2209

AWS A5.4 E2209-16

## Chemical Composition of Inweld 2209

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.04	21.5- 23.5	8.5- 10.5	2.5-3.5	0.5-2.0	0.90	0.04	0.03	0.08- 0.20	0.75

Single values are maximum unless otherwise specified.

## Description and Applications

Inweld E2209-16 is used primarily to weld duplex stainless steels which contain approximately 22 percent of chromium (grade 2205). Weld metal deposited by Inweld E2209-16 has “duplex” microstructure consisting of an austenite-ferrite matrix. It combines increased tensile strength with improved resistance to pitting corrosive attack and to stress corrosion cracking.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	100,000 psi
Yield Strength:	80,000 psi
Elongation:	20%

## Recommended Parameters

SMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32”		60-75
1/8”		90-110
5/32”		110-150

**INWELDCORPORATION.COM**

**Pennsylvania**  
3962 Portland Street  
Coplay, PA 18037

**North Carolina**  
1029 S. Marietta St.  
Gastonia, NC 28054

**Texas**  
9300 Lawndale St.  
Houston, TX 77012

**California**  
6201 Coliseum Way, Unit A  
Oakland, CA 94621