

INCO-WELD® 2209 is used for joining 2205 type base materials.

*Typical Chemical Analysis (%)

| Element | % | AWS Requirement |
|-----------------|-------|-----------------|
| Carbon (C) | 0.02 | 0.03 max |
| Chromium (Cr) | 22.5 | 21.5-23.5 |
| Nickel (Ni) | 8.5 | 7.5-9.5 |
| Molybdenum (Mo) | 3 | 2.5-3.5 |
| Manganese (Mn) | 1.25 | 0.5-2.0 |
| Silicon (Si) | 0.48 | 0.9 max |
| Phosphorus (P) | 0.002 | 0.03 max |
| Sulphur (S) | 0.001 | 0.03 max |
| Nitrogen (N) | 0.14 | 0.08-0.20 |
| Copper (Cu) | 0.1 | 0.75 max |

*Typical Mechanical Properties

| | |
|-----------------------|-------------|
| Tensile Strength | 109,000 psi |
| Yield Strength | 87,000 psi |
| Elongation | 25% |
| Charpy V-Notch (RT) | 120 ft.lb |

*Typical GMAW welding Parameters

| | Wire Diameter | Amperage | Voltage | Shielding |
|----------------|---------------|----------|---------|-------------------------|
| Short Circuit | .035" | 80-160 | 14-22 | 90% He + 7½% Ar + 2½ O2 |
| | .045" | 110-220 | 15-23 | 90% He + 7½% Ar + 2½ O2 |
| | .062" | 130-250 | 16-23 | 90% He + 7½% Ar + 2½ O2 |
| Spray Transfer | .035" | 175-250 | 23-26 | Ar + 2% O2 |
| | .045" | 225-325 | 24-29 | Ar + 2% O2 |
| | .062" | 300-425 | 26-30 | Ar + 2% O2 |

Approvals

AWS A5.9 ER2209
ASME SFA 5.9
Canadian Welding Bureau

Available Sizes and Packaging

| GTAW | | GMAW | | SAW | |
|----------|--------------------------------|----------|--------------------------------|----------|--------------|
| Diameter | Packaging | Diameter | Packaging | Diameter | Packaging |
| 1/16 | 10 lb. Tubes in 1 m Lengths | .030 | 30 lb. Spools/ Wire Baskets | 3/32 | 60 lb. Coils |
| 3/32 | | .035 | | 1/8 | |
| 1/8 | | .045 | | 5/32 | |
| 5/32 | | 1/16 | | | |

*All information listed is provided as typical values and may differ from actual results due to variations in weld procedures.
IAI disclaims any liability resulting from reliance on any of the above values.

Controlled Products Group

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