

Stainless Steel MIG•TIG Wire/Rod

GM2209 / GT2209

AWS A5.9 ER2209
JIS Z 3321 YS2209
ISO 14343-A-G 22 9 3 N L
14343-A-W 22 9 3 N L

Product Features:

- Low carbon content in weld metal to get good inter-granular corrosion resistance.
- High tensile strength, good pitting, stress corrosion and crack resistance.

Applications:

- Suitable for welding of duplex stainless steel contains 22% Cr such as SUS 2205.

Shielding gas:

- Ar+ 1~2% O₂ (MIG)
- 100%Ar (TIG)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Ni	Cr	N	Mo
0.01	0.45	1.46	8.57	22.75	0.15	3.20

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-50°C) J
691	788	35	224

MIG Size (mm) & recommended welding parameters; DC+

Diameter (mm)	0.9/1.0	1.2	1.6
Current range (Amp)	70~200	90~250	200~300

TIG rod size diameter/length; DC-

Diameter (mm)	1.6	2.0	2.4/2.6	3.2
Length (mm)	1000	1000	1000	1000

Note:

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