

Solid Wire Electrode for MIG/MAG Welding

BA-MIG 2209

Classification: EN ISO 14343-A: **G 22 9 3 N L**
SFA-5.9: **ER2209**

Main Application:

BA-MIG 2209 is a solid wire electrode for GMAW, suitable for welding duplex stainless steels grades 2205 and 2304. Weld metal exhibits corrosion resistance similar to grade 904L in most applications. BA-MIG 2209 is also suitable to weld grade 2205 or grade 2304 to mild steel.

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	N	P	S	Cu total
Typical analysis BA-MIG 2209	≤ 0.02	0.7	1.6	3.2	9.0	23.0	0.15	0.015	0.012	0.10
G 22 9 3 N L acc. to ISO 14343-A	0.03	1.0	2.5	2.5-4.0	7.0- 10.0	21.0-24.0	0.1-0.2	0.03	0.02	0.3
ER2209 acc. to AWS A5.9	0.03	0.9	0.5-2.0	2.5-3.5	7.5-9.5	21.5-23.5	0.08-0.2	0.03	0.03	0.75

All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment	As Welded
Yield Strength Re, N/mm ² (ksi)	> 480 (70)
Tensile Strength Rm, N/mm ² (ksi)	660 - 860 (96 - 125)
Elongation A5 [%]	>22
Impact Energy ISO-V, J (ft lbs)	+20°C: > 80 (58) -50°C: > 47 (34)
Current/polarity	DC +
Shielding Gas	ISO 14175: M12 / M13

Base Materials:

1.4462/ X2CrNiMoN22-5-3, 1.4362/ X2CrNiN23-4, 1.4462/ X2CrNiMoN22-5-3 with 1.4583/ X10CrNiMoNb18-12
UNS S31803, S32205

Package Forms:

Spools BS300/15 kg, D200/5 kg, and drums as standard package forms for GMAW wire electrodes.

Diameter:

0,8 – 1,6 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire Electrode Surface:

Smooth finish free from surface defects and foreign matter.