

# Solid Wire Electrode for Submerged Arc Welding

# BA-WIRE 2209

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

**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-WIRE 2209	0.015	0.5	1.6	3.3	9.1	23.0	0.16	0.015	0.012	0.1
S 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	0.10–0.20	0.03	0.02	0.5
ER2209 acc. to AWS A5.9	0.03	0.90	0.5–2.0	2.5–3.5	7.5–9.5	21.5–23.5	0.08–0.20	0.03	0.03	0,75

## Application:

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

## Base Materials:

- 1.4462/ X2CrNiMoN22-5-3, 1.4362/ X2CrNiN23-4, 1.4462/ X2CrNiMoN22-5-3 with 1.4583/ X10CrNiMoNb18-12  
UNS S31803, S32205  
Suitable fluxes: BF 38SD, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

## Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

## Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

## Wire electrode surface:

Smooth finish free from surface defects and foreign matter.