

Lincoln® MIG 4462

Key Features

- Premium 2209 solid wire for welding duplex stainless steels
- High resistance to general corrosion, pitting and stress corrosion cracking
- Precision layer wound wire assists feeding and resists wire tangles

Typical Applications

- Suitable for welding 2205 type duplex stainless steels
- Also suitable for welding 2205 stainless to carbon steels
- UNS S31803, S31500

Conformances

AWS A5.9/A5.9M: ER2209

Welding Positions



Shielding Gas

- 98-99% Argon / 1-2 % O₂ (spray transfer)
- 98-99% Argon / 1-2% CO₂ (short circuit)
- Flow Rate: 15-20 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS ipm	Voltage volts	Current amps	CTWD mm
1.2	331042	Spool S300 15kg	125-360	19-23	100-185	15-20

Mechanical Properties - As required per AWS A5.9

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -46°C
Requirements - AWS ER2209	Not specified	Not specified	Not specified	Not specified
Typical Results	625	810	28	40

Wire Composition

	%C	%Mn	%Si	%Cr	%Ni	%Mo	%N
Typical Results	0.01	1.7	0.4	22.9	8.8	3.1	0.15