

INERTFIL 22 9 3

TOP FEATURES

- Used for the welding of duplex stainless steels in a range of applications
- The weld metal has a PREN value >35 giving a high resistance to pitting and stress corrosion cracking especially in high chloride media.
- Excellent corrosion resistance and mechanical characteristics of the deposit

TYPICAL APPLICATIONS

- Pipelaying
- Shipbuilding
- Petrochemical

CLASSIFICATION

AWS A5.9	ER2209
EN ISO 14343-A	G 22 9 3 N L

SHIELDING GASES (ACC. EN ISO 14175)

M12	Mixed gas Ar+ 0.5-5% CO ₂
M13	Mixed gas Ar+ 0.5-3% O ₂

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Cr	Ni	Mo	N
0.020	1.7	0.5	≤0.025	≤0.020	23	9	3	0.15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-40°C
Typical values	AW	≥480	≥690	≥22	≥50	≥32

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (BS300)	15.0	W000283138
1.2	SPOOL (BS300)	15.0	W000283139

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.