WELDWIRE COMPANY, INC. **Technical Information**

Stainless Steel Electrodes

Alloy: WW2209-16 Class: E2209-16

Conforms to Certification: AWS A5.4 ASME SFA A5.4

Alloy: E2209-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.04 max	Si = 1.0 max
Cr = 21.5 – 23.5	P = 0.04 max
Ni = 8.5 – 10.5	S = 0.03 max
Mo = 2.5 – 3.5	Cu = 0.75 max
Mn = 0.5 – 2.0	N = 0.08 – 0.20

Deposited All Weld Metal Properties %
(Typical) As-Welded

Yield Strength	115,000psi
Tensile Strength	90,000psi
Elongation	27%

Deposited Chemical Composition % (Typical)

C = 0.03	Si = 0.45
Cr = 23.00	Mn = 0.95
Ni = 9.70	Mo = 3.00

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

Diameter	Voltage	Amperage Flat Position	Amperage Vertical & Overhead
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130

Application

E2209-16 is used to weld duplex stainless steels. Welds offer excellent resistance to stress corrosion and cracking.

If additional information is needed Contact Weldwire Company, Inc. 800-523-1266