

# Shield-Bright 2209

AWS A5.22 E2209T1-1(4) / JIS Z3323 TS2209-FB1

Flux  
CORED  
WIRES

## Description and Application

- Shield-Bright 2209 was developed for the welding of '2205' duplex stainless steels e.g. UNS S31803, S32205, and J92205. It can also be used for the welding of leaner grades of duplex stainless steels. It has been approved with a 25°C critical pitting temperature and impact toughness at -40 °F (-40 °C). Shield-Bright 2209 was developed for welding in all positions and performs particularly well in the vertical position with excellent slag removal.

## Shielding Gas : 100%CO<sub>2</sub> or 75%Ar/25%CO<sub>2</sub>

### Typical Mechanical Properties of All Weld Metal

Shielding gas	Yield Point N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Tensile Strength N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Elongation (%)
100%CO <sub>2</sub>	617 {63}	825 {84}	32
75%Ar/25%CO <sub>2</sub>	650 {66}	820 {83}	25

### Typical Undiluted Weld Metal Analysis %

Shielding gas	C	Mn	Si	P	S	Cr	Ni	Mo	N	Ferrite No.
100%CO <sub>2</sub>	0.03	1.40	0.60	0.025	0.012	23.2	8.7	3.21	0.14	35-50
75%Ar/25%CO <sub>2</sub>	0.03	0.90	0.35	0.025	0.012	22.5	9.2	3.2	0.16	35-50

### Approvals

ABS, DNV, BV, GL, CCS, JIS