

INERTFIL 22 9 3

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 22 9 3 is a solid wire suitable for welding duplex stainless steels. The weld metal has excellent corrosion resistance and weld metal mechanical properties.

Classification	
AWS	A5.9: ER 2209
EN	12072: G 22 9 3NL

Approvals	Grades
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.02	1.70	0.50	≤ 0.030	≤ 0.020	23	9	3	-	-	0.15	30-65

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 450	≥ 600	≥ 26	≥ 80 J	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

1.4462 (X2CrNiMoN22-5-3)

UNS S31803 - S31500 - S31200 - S32304

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



PA PB PC PF PE PF2

Packaging data: BS300 Kg. 15

Diameters	0,8	1,0	1,2			