

TECHNIWELDUSA

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TYPICAL MATERIAL TEST REPORT

ITEM CLASSIFICATION	
ALLOY	SPECIFICATION
E2209TX-X	AWS A5.22
APPLICATIONS	
Used to join duplex stainless steel base metals containing approximately 22% chromium.	

TYPICAL CHEMICAL COMPOSITION						
ELEMENT	C	Mo	P	Cr	Mn	
AVERAGE	0.03	3.5	0.002	22.0	1.5	

ELEMENT	S	Ni	Si	N		
AVERAGE	0.001	8.5	0.55	1.00		

TYPICAL MECHANICAL PROPERTIES			
	Tensile Strength	Yield strength	Elongation
	(N/mm ²)	(N/mm ²)	%
		101,000 psi	87,000

WELDING PROCESS		
	Shielding Gas	75% argon / 25% CO ₂ (or nearest equivalent)
	Post Welding	as-welded