



WA. ALLOY CO.

WASHINGTON ALLOY'S Quality
Management System is
Certified to **ISO 9001:2008**
Cert # 05-R0925

USA 2209-16 Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

USA 2209-16 duplex stainless steel electrodes are used to weld 22% chromium duplex stainless steel such as 2205, 2209, 2304 and other proprietary duplex stainless steels. It has a smooth running arc that deposits very high tensile strength, with resistance to stress, corrosion, cracking and pitting. These all-position rods have easy strike and re-strike with spatter-free arc, self-releasing slag leaving a smooth bead appearance. 2209 may also be a good choice when welding Duplex stainless such as 2553 to carbon steels or other grades of stainless.

TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps
3/32"	60-75
1/8"	90-110
5/32"	110-150

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. When welding vertical reduce amperage 10-20%

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.04	Molybdenum	2.50-3.50
Manganese	0.50-2.0	Phosphorus	0.04
Silicon	0.90	Sulfur	0.03
Chromium	21.50-23.50	Nitrogen	0.08-0.20
Nickel	8.50-10.50	Copper	0.75
	Elongation		25%
	Yield Strength (psi)		87,000
	Tensile Strength (psi)		109,000

Iron balance and all single values are maximum percentages

AVAILABLE SIZES: TF 2209-16 = 3/32", 1.8", 5/32"

Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.4 E2209-16
ASME SFA 5.4 E2209-16

EAST COAST
7010-G Reames Rd
Charlotte, NC 28216
Tel (888) 522-8296
Fax (704)598-6673

GULF COAST
4855 Alpine Drive #100
Stafford, TX 77477
Tel (877) 711-9274
Fax (281)313-6332

WEST COAST
8535 Utica Ave
Rancho Cucamonga, CA 91730
Tel(800)830-9033
Fax (909)291-4586



2012 DC

Warehouse Distribution Center – Dayton, Ohio

Head Office – Puyallup, Washington

Washington Alloy Company believes that all information and data given is correct. Use this information to assist in making your own evaluations or decisions and this information should not be mistaken as an expressed or implied warranty. U.S. ALLOY CO. assumes no liability for results or damages incurred from the use of any information contained herein, in whole or in part.