



DW-2209

**Classification: AWS A5.22 E2209T1-1
AWS A5.22 E2209T1-4**

All-Weld-Metal (75%Ar - 25%CO₂)

1-1. Chemical Composition

[Unit: mass%]

	C	Mn	Si	P	S	Cr	Ni	Mo	N
DW-2209	0.02	0.89	0.55	0.018	0.005	22.96	9.68	3.28	0.14
E2209T1-X	<0.04	0.5~2.0	<1.0	<0.04	<0.03	21.0~24.0	7.5~10.0	<0.5	0.08~0.20
	WRC ₁₉₉₂ (FN)		PRE *1		*1) Pitting Resistance Equivalent = Cr + 3.3 X Mo + 16 X N				
DW-2209	40.5		36.0						
E2209T1-X	-----		-----						

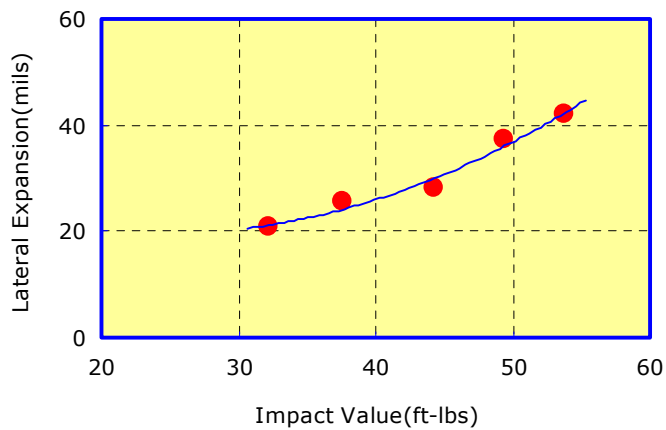
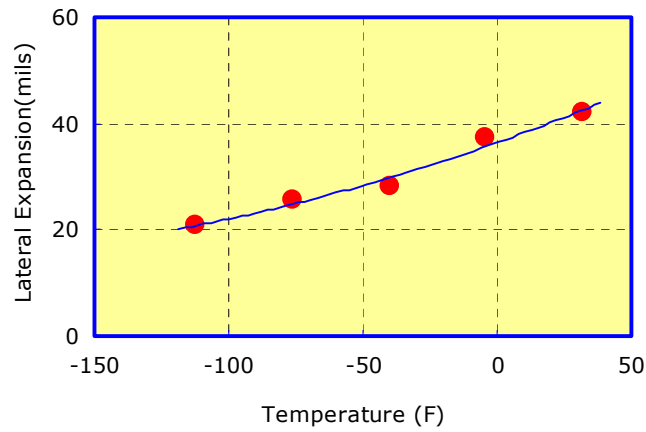
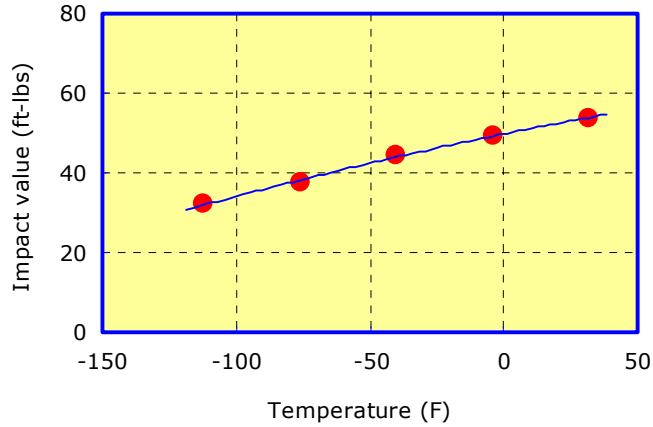
1-2. Tensile Test

	0.2% Proof stress (psi)	Tensile strength (psi)	Elongation (%)	Reduction of Area (%)
DW-2209	89,490	117,190	31	48
E2209T1-X	---	>100,000	>20	---

Note) Test was completed in the as welded condition and at room temperature

Kobelco Welding of America. Inc.

1-3. Impact Test



1-4. Corrosion Test

Test Condition	Corrosion Loss / g/m ² ·h	Judgment
68°F - 24hr	0.005	No Pitting
77°F - 24hr	0.032	No Pitting

* According to ASTM G48 Practice A



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

Kobelco Welding of America, Inc.