



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](http://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.