

Classification

AWS A5.4	EN ISO 3581-A	GB/T 983
E2209-16	E 22 9 3 N L R	E2209-16

Characteristics and typical fields of application

22Cr-9Ni-3Mo duplex stainless steel rutile coated electrode.

Its deposited metal has good pitting corrosion resistance below 250 ° C. It has good resistance to stress corrosion under the condition of hydrogen sulfide. Applicable to the welding process of the corresponding type of duplex stainless steel structure.

Base Materials

Outokumpu 2205; EN 1.462; ASTM S32205; BS 318S13; NF Z3 CND 22-05 Az; SS 2377

Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	Cr	Ni	Mo	Cu	N
0,02	0,7	0,60	22,8	9,1	3,0	0,04	0,15

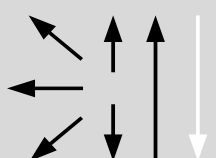
Ferrite Number \approx 35-65 FN WRC 92

PREN: 35

Mechanical properties of the weld metal

Heat Treatment	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=4d_0$)	Impact work ISO-V K_V (J)	
	MPa	MPa	%	+20°C	-46°C
As Welded	630 (\geq 450)	820 (\geq 690)	25(\geq 20)	45 (\geq 27)	35 (\geq 27)

Operating Data

	Polarity DC (+) / AC	Interpass temperature : 150°C Heat Input: Max. 2.0 KJ/mm Re-drying for 3 h at 250 – 280°C Very high quench rate and excessive time at red heat or above should be avoided to prevent excessive ferrite or formation of intermetallic phases
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Approval

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Size, Packing and Recommended welding parameters

Size (mm)	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 350	5,00	15,00	50-80
3.25 x 350	5,00	15,00	80-120
4.00 x 350	5,00	15,00	100-160
5.00 x 450	5,00	15,00	160-220