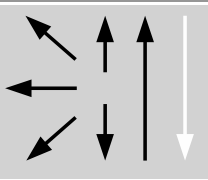


Classification						
<b>AWS A5.4</b>		<b>EN ISO 3581-A</b>				
E2209-17		E 22 9 3 N LR				
Characteristics and typical fields of application						
Cr, Ni Mo alloyed duplex electrode for welding duplex steel such as 2205. For light to moderate thickness material, welding should be carried out as for ordinary austenitic stainless steel. However the somewhat lower penetration and fluidity of the weld should be considered. Very high quench rate and excessive time at red heat or above should be avoided to prevent excessive ferrite or formation of intermetallic phases.						
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	N
0.025	0.87	0.63	22.94	9.57	2.89	0.15
Ferrite Number ≈ 50 FN WRC92						
Mechanical properties of all-weld metal						
Heat treatment	Yield strength R <sub>e</sub> N/mm <sup>2</sup>	Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		
	MPa	MPa	%	+ 20 °C	-40°C	
Min. AWS A5.4	-	690	20	-	-	
As Welded	685	850	26	38	31	
Operating data						
		<b>Polarity</b> DCEP / AC	Heat Input: 0.5 – 2.5 kJ/mm Interpass temperature: Max. 150°C Scaling Temperature : Approx. 850°C Instruction for Re-drying: Re-dry for 3 h at 250-280°C before using			
Approvals						
ABS						
Size, Packaging and Electrical Operating Data						
Size mm	Kg / Pack		Kg / Box		Amperage (A)	
2.50 x 350	5.0		15.0		45-80	
3.25 x 350	5.0		15.0		70-120	
4.00 x 450	5.0		15.0		90-160	
5.00 x 450	5.0		15.0		150-220	