



Selectarc Inox 2308

*Rutile type coated electrode
For Duplex Stainless Steel*

Classification

AWS A 5.4 : E2209-17 EN 1600 : E 22 9 3 N L R 3 2
ISO 3581-A : E 22 9 3 N L R 3 2

Description & Applications

Rutile coated electrode with an austenitic-ferritic microstructure (duplex). The weld deposit is characterized by a high resistance against pitting, crevice and stress corrosion in chloride containing media, like sea water, combined with a very high tensile strength. The weld metal can be applied for operation temperatures up to 250°C. The main application is for welding of steels and castings with an austenitic-ferritic structure of a similar composition.

Easy to weld with, stable arc, easy to remove slag, regular weld beads.

Main applications : For welding casted parts which require high ferrite (ferrite according to WRC 92 > 35 FN).

Base materials

UNS	Alloy	EN 10088	Material N°
S32900	329	X3CrNiMoN27-5-2	1.4460
		G-X6CrNiMo24-8-2	1.4463
J92205		GX2CrNiMoN22-5-3	1.4470

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	N	P	S	Cu	Fe	FN
≤0.030	0.9	1.0	23.0	8.7	3.2	0.18	0.020	0.005	0.5	Rem.	40

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
>550	>700	≥22	+20°C	>50
			-40°C	>37

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	50-70	70-90	90-120	120-150

Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times the core wire diameter).

Interpass temperature : <150°C.



= + ~ 70V

FT En-E053I-1408



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.