

## Classifications

AWS A5.4	EN ISO 3581-A	GB/T983
E2209-15	E 22 9 3 N L B	E2209-15

## Characteristics and typical fields of application

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

Resistant to intergranular corrosion and pitting corrosion. Good resistance to stress corrosion cracking in chlorine and hydrogen sulphide bearing environments.

Suitable for chemical pressure vessel and chemical ship of hydrogen sulphide resistant requirements.

## Base materials

X2CrMoN22-5(1.4462), UNS 31803, S32205.

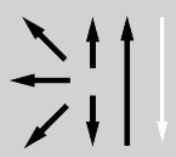
## Typical analysis of all-weld metal (Wt.%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	N	
0.02	0.56	1.36	0.020	0.006	23.3	8.95	3.24	0.06	0.16	

## Mechanical properties of all-weld metal – typical values (AWS B4.0M)

Condition	R <sub>p0,2</sub>	R <sub>m</sub>	A <sub>4</sub>	K <sub>V</sub> (J)	
	MPa	MPa	%	-20°C	-40°C
AW	685(≥480)	860(≥690)	30(≥ 22)	75(≥54)	65(≥54)

## Operating data

	Polarity:	Re-drying if necessary:	Size (mm)
	DC +	300-350°C, 1-2 h	2.5x350 3.2x350 4.0x350

## Approvals

CE