

Classifications

EN 1600:1997 : E 22 9 3 N L R 12
 AWS A5.4-06 : E2209-16

JIS Z 3221 : ES2209-16

Description

- Covering is lime titania type for welding of 22%Cr-9%Ni-3%Mo duplex stainless steels, the principal applications are chemical plant and shipbuilding as well as nuclear plant industries. (UNS S31803)
- Excellent pitting corrosion resistance and stress corrosion cracking resistance.
- Please perform welding with selecting proper heat input according to the required mechanical properties.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	N
0.02	0.62	0.80	0.025	0.011	9.3	21.9	3.2	0.18

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 690	min. 20	
EN 1600	min. 450	min. 550	min. 20	
Example	550	780	24	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V · OH	50~80 40~60	80~110 70~100	110~150 90~130	140~180 —

Approvals

CE