

Duplex S.S. SMAW Electrodes

G2209

AWS A5.4 E2209-16
JIS Z 3221 ES2209-16
ISO 3581-A-E2293 N L R 1 2

- Lime titanium oxide type covered electrode for duplex stainless steel.
- Weld metal contains approximately 22% Cr- 9%Ni-3% Mo-0.15N elements.
- High tensile strength, good pitting, stress corrosion and crack resistance.

Applications:

- Suitable for welding of duplex stainless steel contains 22%Cr such as SUS 2205.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	N	Cu	Fe
0.037	0.82	1.15	9.3	22.8	3.31	0.142	0.110	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-50°C) J
727	841	28	36

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	3.2/350	4.0/350	5.0/350
Flat position	85~120	115~150	140~180
Vertical / overhead position	75~105	95~130	----

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
All Right Reserved

GOOD
GOODWELD
www.goodweld.com.tw