

Duplex S.S. SMAW Electrodes

G2209

AWS A5.4 E2209-16
JIS Z 3221 ES2209-16

Product Features:

- 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
0.03	0.58	0.77	9.4	22.9	3.2	0.16

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
856	26

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

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~115	115~150	150~200
Vertical / overhead position	50~75	75~95	95~130	----

Note:

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