

Duplex S.S. SMAW Electrodes

G2209-15

AWS A5.4 E2209-15
JIS Z 3221 ES2209-15

Product Features:

- Basic coating of stainless steel electrodes has outstanding welding performance for vertical and overhead positions.
- 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
0.037	0.45	1.05	8.92	22.3	3.1	0.158

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %	FN
817	31	33

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	60~80	85~100	110~140	140~170
Vertical / overhead position	50~70	75~90	100~130	----

Note:

- 250~300°C x 1hr baking prior to use.

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