

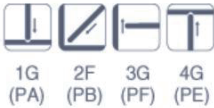
E2209-16

AWS A5.4/A5.4: E2209-16

Description:

E2209-16 is rutile type super low carbon duplex stainless steel welding electrodes used to weld duplex stainless steels such as UNS Number N3 1803. The welds offer excellent resistance to strength, corrosion, cracking, and pitting. The micro-structure of the weld metal consists of austenite and ferrite, and the ferrite of weld metal will be lower than the ferrite of type 2205 base metal.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	835
Yield strength(MPa):	--
Elongation(%):	26

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0,03	1,04	0,025	0,010	0,66	8,75	23.0	2.98	0,15
0								

Welding Current:(AC/DC±)

Diameter(mm)	2,5	3,2	4,0	5,0
Current/A	F/H 60-90	80-120	100-140	150-210
Current/A	V/OH 40-70	60-100	80-140	-

Note:

- 1.The electrodes should be baked 1 hours in 300-350°C before using.
- 2.Remove the rust, water, oil from the work piece before welding
- 3,Control the input heat during welding to prevent electrode crack and burning.