

Classifications

EN ISO 3581-A:2016	E 22 9 3 N L R 12	JIS Z 3221-2013	ES2209-16
EN ISO 3581-B:2016	ES2209-16		
AWS A5.4-2014	E2209-16		

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	PREN
0.02	0.62	0.80	0.025	0.011	8.73	22.63	3.19	0.18	35.0

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 690	min. 20	
EN ISO 3581-A	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

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.