



Selectarc Inox 2209B

*Basic Coated Electrode
For Duplex Stainless Steels*

Classification

AWS A 5.4 : E2209-15
ISO 3581-A : E 22 9 3 N L B 4 2

EN 1600 : E 22 9 3 N L B 4 2

Description & Applications

Basic coated electrode with an austenitic - ferritic microstructure (duplex). The weld deposit is characterised by a high resistance against pitting, crevice and stress corrosion in chloride containing media, like sea water, combined with a very high tensile strength. The weld metal can be applied for operation temperatures up to 250°C. For butt welding and cladding of steels and castings with an austenitic- ferritic structure of a similar composition. Easy to weld with, stable arc, easy to remove slag, regular weld beads.

Main applications: For pumps, vessels , piping systems etc. attacked by chloride containing solutions. But also for impellers and other components which require high strength combined with corrosion attack.

Base materials

| UNS | Alloy | EN 10088 | Material N° | CLI |
|--------|-------|------------------|-------------|------------|
| S31803 | | X2CrNiMoN22-5-3 | 1.4462 | URANUS 45N |
| S32304 | 35N | X2CrNi23-4 | 1.4362 | URANUS 35N |
| S32900 | 329 | X3CrNiMoN27-5-2 | 1.4460 | |
| | | G-X8CrNiN26-7 | 1.4347 | |
| | | G-X6CrNiMo24-8-2 | 1.4463 | |

Typical Weld Metal Composition (%)

| C | Si | Mn | Cr | Ni | Mo | N | Fe |
|--------|-----|-----|------|-----|-----|------|------|
| <0.030 | 0.5 | 1.0 | 22.5 | 9.0 | 3.0 | 0.18 | Rem. |

All Weld Metal Mechanical Properties

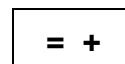
| R _{p0.2} (MPa) | R _m (MPa) | A ₅ (%) | KV (J) |
|---------------------------|------------------------|----------------------|--------------------------|
| 620 | 810 | 25 | +20°C >100 - 40°C >80 |

Welding Current & Instructions

| Electrode | ØxL (mm) | 2,5x300 | 3,2x350 | 4,0x350 |
|-----------|------------|---------|---------|---------|
| Current | (A) | 50-75 | 70-100 | 90-150 |

Redrying 2-3h at 250-300°C. Guide electrodes with a slight declination and weld with a short arc. Interpass temperature: <150°C.

FT En-172-170831



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