



Selectarc Inox 2209B

*Basic Coated Electrode
For Duplex Stainless Steels*

Classification

AWS A 5.4 : E2209-15 EN 1600 : E 22 9 3 N L B 4 2
ISO 3581-A : 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

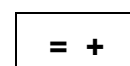
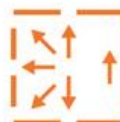
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
620	810	25	+20°C >70 -40°C >40

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.

Ind.12



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