SUNWELD 2209

Duplex Stainless Steel Electrode

CLASSIFICATION

AWS A 5.4 : E 2209-16

CHARACTERISTICS

SUNWELD 2209 is a rutile electrode specially designed for welding of S32500, S31803 types of ferritic-austenitic stainless steels. The composition of weld met is designed to give mechanical and corrosion properties that fully comply with these grades. It combines increased tensile strength with improved resistance to pitting corrosive attack and to stress corrosion cracking.

APPLICATIONS

Suitable for welding duplex stainless steels having Cr ≤ 25% and find its applications in offshore platform pipe work for seawater cooling systems & fire fighting water as well as pumps, valves & risers. Also it can be used for joining duplex stainless to carbon or low alloy steel & for cladding these steels

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

C	Mn	Si	Cr	Ni	Mo	S	P
0.028	0.85	0.80	22.50	9.00	3.00	0.019	0.020

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Ultimate Tensile Strength	Elongation (GL=4d)
579.0 N/mm^2	38.4 %

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	60-80	2 Kg	10 Kg
3.15	450	80-100	2 Kg	10 Kg
4.00	450	100-140	2 Kg	10 Kg
5.00	450	140-180	2 Kg	10 Kg

RECOMMENDATIONS:

Re-dry the electrodes at 200°C for one hour. Use stainless steel wire brush for cleaning the welds.