

Duplex S.S. SMAW Electrodes

KE2209

AWS A5.4 E2209-16
JIS Z 3221 ES2209-16

Product Features:

- Lime titanium oxide type covered electrode for duplex stainless steel.
- Weld metal contains approximately 22% Cr- 9%Ni-3% Mo-0.15N elements.
- High tensile strength, good pitting, stress corrosion and crack resistance.

Applications:

- Suitable for welding of duplex stainless steel contains 22%Cr such as SUS 2205.

Typical chemical composition of all weld metal (wt%)						
C	Si	Mn	Ni	Cr	Mo	N
0.03	0.58	0.77	9.4	23.4	3.35	0.22

Typical mechanical properties of all weld metal	
Tensile Strength N/mm ²	Elongation %
856	26

Size (mm) & recommended welding parameters (A) AC or DC+				
Diameter / Length	2.6/250	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	115~150	150~200
Vertical / overhead position	50~75	75~105	95~130	----

Note:

ecoweld®

CMI

50 Toegye-ro 18-gil, Jung-gu
Seoul, South Korea
www.ecoweldkorea.com