

S-2209.16

Type : Rutile

Conformances

AWS A5.4/ ASME SFA5.4 E2209-16
JIS Z3221 ES2209-16
EN ISO 3581-A-E 22 9 3 N L
KR AWS A5.4 E2209-16
ABS AWS A5.4 E2209-16 (-46°C ≥27 J)

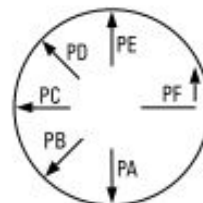
Applications

- Welding of duplex stainless steel (SAF2205, UNS S31803)

Features

- Ferritic/austenitic structure (All-weld metal)
- Service temperature up to 250°C
- High resistance to pitting, intergranular and stress corrosion
- PREN 35
- Easy to remove slag
- Good bead appearance

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	P.V.C	
		packet	carton
		2.5kg(5.5lbs)	10kg(22lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Ni	Mo	N
0.029	0.78	1.03	23.1	9.2	3.1	0.12

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
830 (120,400)	28.0	-20(-4) -50(-58)	50 (37) 45 (33)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	-

Diam.	Pack	Part No.
2.6mm	2.5kg Tube	HKS220926
3.2mm	2.5kg Tube	HKS220932

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