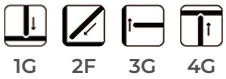
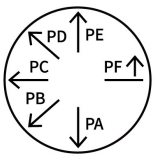
S-2209.16

Classification

AWS A5.4/ASME SFA-5.4 E2209-16
JIS Z 3221 ES2209-16
EN ISO 3581- A E 22 9 3 N L

Welding Positions





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

Polarity

AC or DC+

Application Areas

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

Redrying Conditions

350°C (662°F) X 1hr

Approvals

ABS	CCS	KR	NK	RINA	CE
✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N
0.03	0.76	0.9	0.017	0.012	0.04	8.9	22.6	3.2	0.13

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
830(120)	28	-20(0) -45(-50)	38(28) 30(22)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.0 (5/64)	300 (12)	25~55	20~50	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
2.6 (3/32)	300 (12)	50~85	45~80	
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	350 (14)	95~145	85~135	
5.0 (3/16)	350 (14)	135~180	-	