

**Selectarc 2209 AC/DC+****STAINLESS STEEL****DESCRIPTION**

**Stainless electrode for duplex steels.** Rutile-basic electrode with an austenitic-ferritic microstructure ( duplex ). Easy to weld in all positions, except vertical down. Stable arc, regular drop transfer, easy slag removal, finely rippled weld beads. The weld metal can be applied for operation temperatures up to 250°C (480°F) and is resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion.

**CLASSIFICATION**

AWS A 5.4 : E2209-17      EN 1600 : E 22 9 3 N L R 32

**TYPICAL APPLICATIONS**

For butt welding and cladding of steels and castings with an austenitic-ferritic structure, which are used 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. **Recommended for welding of duplex stainless steel grade 2205.**

**BASE MATERIALS :** 35N, 329, 2205

**PROCEDURE**

Rebaking 2-3 hours at 250-300°C. Guide electrodes with a slight declination and weld with a short arc. Interpass temperature : < 170°C.

**MECHANICAL PROPERTIES**

Tensile strength:      > 99 000 psi (> 680 MPa)  
 Yield strength:      > 78 000 psi (> 540 MPa)  
 Elongation:      > 22 %  
 Impact (Charpy V):      > 50 J at +20°C, > 37 J at -40°C

**TYPICAL WELD METAL COMPOSITION (%)**

C	Mn	Si	Cr	Ni	Mo	N	Fe
<0.03	0.90	0.90	22.5	9.0	3.0	0.18	Rem

**WELDING PARAMETERS**

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	90 - 150 A	70 -100 A	50 - 75 A

**WELDING POSITIONS**

1G/PA      2F/PB      2G/PC      3G/PF      4G/PE

Also available in GMAW wire **MIG 2209**, FCAW wire **FC 2209-AP** and GTAW rod **TIG 2209**.

Rév. : 21\_08

*Specialized welding alloys and technology. For technical assistance or for ordering:*