Jungo® 4462

CLASSIFICATION

AWS A5.4 : E2209-15
EN 1600 : E 22 9 3 N L B 22

TEMPERATURE RANGE

Pressurized parts :-50 ...+250°C
Oxidation resistance : n.a

GENERAL DESCRIPTION

A basic electrode for 22% Cr duplex stainless steel welding
Excellent weldability for filling as well as for root runs
Applicable up to a service temperature of 250°C
High resistance to general corrosion, pitting and stress corrosion (PREN ~35)
High yield strength > 500 N/mm²
Weldable on DC+ polarity
Also available in vacuum sealed Sahara ReadyPack® (SRP)

WELDING POSITIONS

ISO/ASME PA/1G PB/2F PC/2G PF/3G up PE/4G PF/5G up

CURRENT TYPE

DC +

APPROVALS

DNV

+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Mo	N	FN (acc.WRC 1992)
0.025	1.6	0.5	23.5	9.0	3.0	0.15	30-60

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	0.2% Proof strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) +20°C	-20°C	-40°C	-50°C
Required: AWS A5.4		not required	min. 690	min. 20	not required			
EN 1600		min. 450	min. 550	min. 20	not required			
Typical values	AW	650	800	28	80	75	70	45

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5	3.2	4.0
	Length (mm)	350	350	350
Unit: carton box	Pieces / unit	112	152	103
	Net weight/unit (kg)	2.3	5.0	5.0
Unit: SRP	Pieces / unit	69	55	30
	Net weight/unit (kg)	1.4	1.8	1.5

Identification Imprint: 2209-15 / JUNGO 4462 Tip Color: red

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MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2/-4	Mat. Nr	ASTM / ACI A240	UNS
Duplex stainless steels				
	X2CrNiMoN22 -5-3	1.4462		S31803
		1.4417		S31500
	X3CrNiMoN27-5-2	1.4460		S31200
	X2CrNiN23-4	1.4362		S32304
	X2CrMnNi21-5-1	1.4162		S32101

Dissimilar joints such as un- and low alloyed steel to duplex stainless steel

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (S)*	Energy - per electrode at max. current - E(kJ)	Dep. rate - per electrode at max. current - H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
2.5 x 350	50-80	DC+	74	101	0.62	21.0	78	1.64
3.2 x 350	70-110	DC+	84	219	0.88	33.8	49	1.64
4.0 x 350	100-140	DC+	80	304	1.4	50.8	32	1.61

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G	PF/5Gup
2.5	60A	60A	60A	60A	60A	60A
3.2	85A	80A	90A	80A	80A	80A
4.0	120A					

REMARKS / APPLICATION ADVICE

Interpass temperature depends on construction (max. 150°C)