

EASYARC™ 2209**CLASSIFICATION**

AWS A5.4 E2209-16
 GB/T 983 E2209-16
 EN1600 E22 9 3 N L R

CHARACTERISTICS & APPLICATION

- 22.5%Cr-9.5%Ni-3%Mo-0.15%N type duplex stainless steel weld metal;
- Intended for welding of 22% Cr duplex stainless steel, such as UNS S31803 (2205 alloy);
- The weld metal is both with high strength properties and good pitting corrosion resistance and stress corrosion cracking resistance ability;
- Good for all position welding.

DIAMETERS / PACKAGING

Diameter × Length (mm × mm)	Standard Package - Weight (kg)*	
	Inner Plastic Box	Outer Master Carton
2.0 x 300	1	20
2.6 x 300	2	24
3.2 x 350	2&5	20
4.0 x 350	2&5	20
5.0 x 350	5	20

* PERMAPACK™ (Vacuum sealed package) is also available on request.

ALL WELD METAL MECHANICAL PROPERTIES, TYPICAL VOLUME

Electrode	Condition	Yield Strength Rp0.2 (MPa)	Tensile Strength Rm (Mpa)	Elongation A5 (%)	CVN Impact Strength		
					0°C	-20°C	-40°C
AWS E2209-16	As-welded	—	≥690	≥20	—	—	—
GB E2209-16	As-welded	—	≥690	≥20	—	—	—
EN1600 E22 9 3 N L R	As-welded	≥450	≥550	≥20	—	—	—
EASYARC™ 2209	As-welded	560	800	30	—	—	—

UNDILUTED WELD METAL CHEMICAL COMPOSITIONS, TYPICAL (Wt-%)

Electrode	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
AWS E2209-16	≤0.04	21.5-23.5	8.5-10.5	2.5-3.5	0.5-2.0	≤1.0	≤0.040	≤0.030	≤0.75	0.08-0.20
GB E2209-16	≤0.04	21.5-23.5	8.5-10.5	2.5-3.5	0.5-2.0	≤0.9	≤0.040	≤0.030	≤0.75	0.08-0.20
EN1600 E22 9 3 N L R	≤0.04	21.0-24.0	7.5-10.5	2.5-4.0	≤2.5	≤1.2	≤0.030	≤0.025	—	0.08-0.20
EASYARC™ 2209	0.028	22.91	9.28	3.25	1.10	0.90	0.017	0.011	0.16	0.16

RECOMMENDED WELDING PARAMETERS (CURRENT POLARITY: AC & DC+)

Diameter × Length (mm × mm)	Welding Position	2.0 x 300	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 350
		Current (A)	1G, 2G, 2F 3G up, 4G	35-55 30-50	50-85 45-85	80-120 70-110

Customer Assistance Policy

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