

# ROYAL 2209 (E 2209 -16)

AWS / SFA 5.4 E 2209 -16 EN ISO 3581 A E 22 9 3 N

## Applications

It is used for welding of duplex stainless steel material where the weld metal deposited combines increase tensile strength with improve resistance to pitting corrosive.

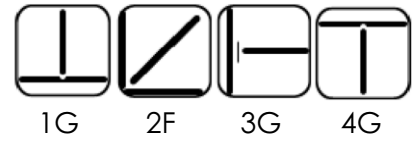
## Characteristics on Usage

The normal composition (wt. %) of this weld metal is contain 22.2 %Cr, 9.5 % Ni & 0.15% N. Electrodes of this composition are used primarily to weld duplex stainless steels which contain approximately 22% of chromium.

## Packing

Vaccum Pack

## Welding Positions



## Notes On Usage

- ⌚ Dry the electrodes at 350° C for 60 min. before use.
- ⌚ Keep the current as low as possible.
- ⌚ Remove rust, water, oil, paint etc. from groove.

STAINLESS STEEL ELECTRODES

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%	Cu %	N%
0.040Max	0.50- 2.00	1.00 Max	0.030 Max	0.040 Max	22.5 -23.5	8.5 - 10.5	2.5-3.50	0.75Max	0.08- 0.20

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
690	20-28

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 x 350	2	10	4.40	22.05	50 - 90	AC / DC + Ve
3.20 x 350	2	10	4.40	22.05	90 - 140	
4.00 x 350	2	10	4.40	22.05	120 - 170	
5.00 x 350	2	10	4.40	22.05	180 - 220	