

Shielded Metal Arc Welding

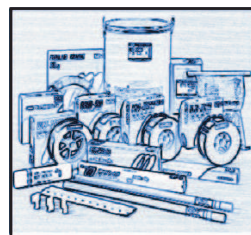
ANU BOND - 2209 (E 2209 - 16)

AWS :SFA 5.4,E 2209 - 16

Stainless Steel Electrodes

Application :

It is used for welding for 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, and 0.15% N. Electrode of this composition are used primarily to weld duplex stainless steel which contain approximately 22 % of Cr.

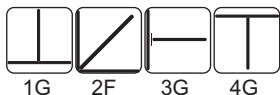
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
0.04 Max	0.50-2.0	1.0 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 all-weld metal as per AWS

UT.S (N/mm ²)	Elongation (L=4d) %
690	20-28

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC / DC + Ve	50-90
3.15 x 350	2	12		90-140
4.00 x 350	2	12		120-170
5.00 x 350	2	12		180-220

