



EI 2209

Coated Electrode for Stainless Steels -

Standards	
AWS/ASME SFA - 5.4	E2209-16
EN ISO 3581 - A	E 22 9 3 N L R 12
TS EN ISO 3581 - A	E 22 9 3 N L R 12

Properties and Applications

Electrode for welding duplex (ferritic-austenitic) stainless Cr-Ni-Mo steels. Especially used in welding of acid tanks and pipes, in chemical, petrochemical, paper, shipbuilding and desalination industries. Suitable also for welding duplex stainless steels to carbon steels. The delta-ferrite content of the as-deposited weld metal amounts to approx. 25 to 35 %. The high-strength and ductile weld metal exhibits good resistance to pitting, crevice corrosion and stress corrosion cracking in chloride-bearing media. For operating Temperatures of up to +250°C. Possible to use equally well both with AC and DC. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy arc striking, restriking and slag removal.

Materials		
EN	Material	ASTM
X2CrNiMoN22-5-3	1,4462	2205

Typical Chemical Values of Weld Metal

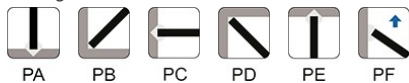
Type of Analysis	C	Si	Mn	Cr	Ni	Mo	N
Weld Deposit	0.02	0.70	1.00	22.5	9.80	3.20	0.10

Typical Mechanical Values of Weld Metal

Test Condition	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	>750	27	20°C → > 47	-20°C → > 35

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x300	50-85
2.50x350	50-85
3.25x350	80-120
4.00x350	90-140
5.00x350	

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
13026GDEM2	2.50x300	132 AD	2.62	3	8.00	Plastic Box
13026GIEM1	2.50x300	80 AD	1.57	9	14.30	VAC Box
13026GJEM2	2.50x300	93 AD	1.79	9	16.30	VAC Box
13026HJEM1	2.50x350	100 AD	2.26	6	13.80	VAC Box
13026HJEM2	2.50x350	91 AD	2.04	9	18.60	VAC Box
13026NEEM2	3.25x350	133 AD	5.21	3	15.80	Plastic Box
13026NJEM1	3.25x350	55 AD	2.13	9	19.40	VAC Box

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13026NJEM2	3.25x350	53 AD	2.04	9	18.60	VAC Box
13026QEEM2	4.00x350	90 AD	5.21	3	15.80	Plastic Box
13026QJEM1	4.00x350	40 AD	2.29	6	14.00	VAC Box
13026QJEM2	4.00x350	36 AD	2.04	9	18.60	VAC Box
13026TJEM1	5.00x350	25 AD	2.11	9	19.20	VAC Box
13026TJEM2	5.00x350	24 AD	2.04	9	18.60	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
It has to be dried at 350°C for 2 hours.



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