

Stick Electrode for Stainless Steel

KS-2209

Classification

AWS	A 5.4	E2209-16
JIS	Z3221	ES2209-16
EN	3581-A	E 22 9 3 N L R
GB	T 983	E2209-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 22.5%Cr-9.5%Ni-3%Mo-0.15%N.
- (2) It provides outstanding strength and excellent resistance to pitting and stress corrosion cracking.
- (3) It is suitable for welding 22%Cr duplex stainless steel, such as UNS S31803 (Alloy 2205).

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instructions and information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.030	0.46	0.80	0.018	0.020	22.71	8.82	3.02	0.13

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Ferrite Number
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%	(FN)
820(83.6)	650(66.3)	32	40

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)		3.2x350	4.0x350
Amp	F/H-Fillet	80~120	100~150
	V-up/OH	70~110	90~135