

ES 2209-16

SMAW

ESWECO
The Art of Welding

Type Rutile

E2209-16

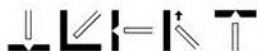
Description

ES 2209-16 is a rutile coated electrode designed for welding ferritic-austenitic duplex stainless steel pipes, e.g. UNS 31803 and 1.4462. The electrode has a thin coating which is ideal for root runs and positional welding.

Typical application: Offshore, Oil and Gas, Chemical and Petrochemical and Welding 2205 Stainless Steels

Current

DC+, AC OCV 55 V



Classifications

EN 1600	E 22 9 3 N L R 1 2
SFA/AWS A5.4	(E2209-16)
Werkstoff Nr.	1.4462

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	N	Cu
<0.03	0.9	0.9	23.0	9.5	3.3	<0.18	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	660
Tensile strength, MPa	840
Elongation A5, %	25

Charpy V

Test temps, °C	Impact values, J
+20	>40

Ferrite content	FN 25-40
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Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	30-80	23
3.2	350	70-110	25
4.0	350	100-140	26