

NC-2209

For duplex stainless steel

AWS A5.4 E2209-16
JIS Z3221 ES2209

Applications

Welding of 19%Cr-9%Ni-3%Mo Duplex stainless steel.

Field of applications are in off-shore engineering and in the chemical industry.

Characteristics

NC-2209 offers excellent position weldability and thus is perfectly suited for pipe welding. Besides the good wetting characteristics, slag removability, resistance to porosity.

Notes on usage

- (1) Keep the arc as short as possible.
- (2) Weaving width should be within two and a half times electrode's diameter.
- (3) When the electrodes have absorbed moisture, dry them at 150~200°C for 30~60 minutes before use.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Ni	Mo	N	Cu
0.02	0.83	0.87	0.019	0.003	21.69	9.68	2.83	0.16	0.07

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %
702(72)	850(87)	26

Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	
	L (mm)	300	350	350	350
Amp.	F	50-80	70-115	100-150	150-200
	V&OH	45-75	65-110	95-140	-