



D&H 2209 (NS)

CODIFICATION : AWS : SFA 5.4 E2209-16

CHARACTERISTICS AND APPLICATIONS :

- Non-synthetic electrode depositing duplex stainless steel weld metal.
- A soft and smooth arc, which is easy to strike and re-strike.
- Better welder appeal including, easy slag detachability characteristics.
- The weld metal is of radiographic quality.

It is ideal for welding duplex stainless steels. The weld metal possesses excellent corrosion resistance in marine & paper environments. Suitable for welding duplex stainless steels having Cr \leq 25% and other grades like UNS 32205, UNS 31803, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Cr	Ni	Mo	N	S	P
Percent :	0.028	1.5	0.4	22.5	8.8	3.0	0.14	0.018	0.020

CORROSION PROPERTY: Weld metal meets ASTM A262 Practice C, ASTM G-36, ASTM G-48A and NACE TM-01-77 specification at 350 MPa stress level, 16 bar pressure and 90°C temperature requirements in as welded condition.

HARDNESS OF WELD METAL : 26 RC Max.

FERRITE : 40-55%

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation	CVN Impact Strength at
(MPa)	(L = 4d)%	Minus 30°C
723	25.0	70 J

BEND TEST: Satisfactory with plunger diameter equal to 4 times the thickness of the specimen.

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	: 150-180	110-140	80-110	60-80
(Amps)				
Weight/Cartron	: 2.5	2.5	2.5	2.5
(kgs)				

PRECAUTIONS:

1. The electrodes should be kept dry. In case of moisture pick-up re-dry the electrodes at 250-300°C for one hour.
2. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input.

Note: D&H 2209-15 (NS) conforming to AWS E2209-15 is also available.