

Standards :

TS EN ISO 3581 - A	: E 22 9 3 N LR 32
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AWS A5.4	: E 2209 - 17

**Chemical Composition of Weld Metal-
% (Typical) :**

C	Si	Mn	Mo	Ni	Cr	N
0.03	0.50	0.9	2.7	10.0	22.0	0.12

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L ₀ =5d ₀)(%)
min. 520	690-850	min.47 J	min. 20

Typical Base Material Grades :

* X2CrNiMoN22-5-3, X2CrNiMoN23-4, X2CrNiMoN22-5-3 with X2CrNiMoNb18-12, X2CrNiMoN22-5-3 with P235GH/
P265GH, S255N, P295GH, S355N, 16Mo3

Features and Applications :

- * Applicability in welding duplex steels.
- * Suitability to joint- and surfacing applications of similar-type austenitic steels and cast steels.
- * Electrode coating of rutile character.
- * Excellent weldability.
- * Very high resistance to stress corrosion cracking and to corrosion at particularly chlorious and sulphurous media.
- * In the liquid conditions at chemical industry, serviceability at temperatures of values up to 280 °C.
- * Re-drying : 300 - 350 °C / min. 2 h

Welding Positions :



Current Type :

- D.C.(+)
- A.C.

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10"	50-90	1570
3.20 x 350	1/8 x 14"	80-120	3450
4.00 x 350	5/32 x 14"	110-160	5200

Approvals :

TSE, CE, ABS, BV, GOST-R, SEPRO