

# S-2209.16

Type : Rutile

## Conformances

AWS A5.4/ ASME SFA5.4 E2209-16  
 JIS Z3221 ES2209-16  
 EN ISO 3581-A-E 22 9 3 N L  
 KR AWS A5.4 E2209-16  
 ABS AWS A5.4 E2209-16 (-46°C ≥27 J)

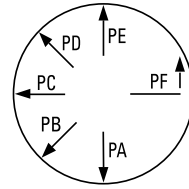
## Applications

- Welding of duplex stainless steel (SAF2205, UNS S31803)

## Features

- Ferritic/austenitic structure (All-weld metal)
- Service temperature up to 250°C
- High resistance to pitting, intergranular and stress corrosion
- PREN 35
- Easy to remove slag
- Good bead appearance

## Welding Position



## Current

AC or DC ±

## Redrying Conditions

350°C (662°F) X 1 hr

## Diameter / Packaging

Diameter mm (in)	Length mm (in)	P.V.C	
		packet 2.5kg(5.5lbs)	carton 10kg(22lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Ni	Mo	N
0.029	0.78	1.03	23.1	9.2	3.1	0.12

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
830 (120,400)	28.0	-20(-4) -50(-58)	50 (37) 45 (33)

## Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	-