

DESCRIPTION

Executive 2209 provides superior weldability, low spatter and smooth beads with easy slag removal. This is a deposited duplex weld metal that offers high strength and improved pitting and SSC resistance.

For welding duplex stainless steels which contain approximately 22% of chromium. Weld metal deposited by these electrodes has "duplex" microstructure consisting of an austenite ferrite matrix and combines increased tensile strength with improved resistance to pitting corrosive attack and to stress corrosion cracking.

APPLICATIONS & FEATURES

With outstanding strength and excellent resistance to pitting and stress corrosion cracking makes Executive 2209 ideal for welding 22%Cr duplex stainless steel.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	N
0.02	0.72	0.85	0.028	0.005	22.69	8.98	3.14	0.10	0.15

Tensile Strength:	118,900 PSI min	Yield Strength:	94,300 PSI min	Elongation:	32%
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TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
SMAW AC/DC	3/32"	12"	40-70
	1/8"	14"	60-100
	5/32"	14"	90-140
	3/16"	14"	120-185

STANDARD PACKAGING & HANDLING

SMAW	40-lb master box
	10-lb plastic tube

CLASSIFICATION

AWS/SFA 5.4, Class **E2209-16**

