

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-2209 is a titanium oxide low hydrogen electrode, the weld metal contains 22%Cr-9%Ni-3%Mo-N the duplex stainless steel comprised of austenite and ferrite steels.
- It is suitable for UNS S31803 (as Alloy 2205).

NOTE ON USAGE :

- Re bake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo	N
0.03	0.89	0.70	0.029	0.013	8.83	23.20	3.05	0.13

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
810(82.7)	25

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	60-85	80-120	100-150	140-170
	V & OH	60-80	65-105	95-140	-