

## Stick electrode

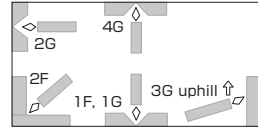
**Features:** ▪ Suitable for normal duplex stainless steel (S32205, S31803, etc.)

**Classification:** AWS A5.4 E2209-16

**Redrying Conditions:** 250~350°Cx1~2h

**Identification color:** -

**Polarity:** AC, DCEP

**Welding Positions:****Packaging data**

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	20	300W, 95H, 330L
3.2	350	5	20	35	175W, 135H, 380L
4.0	350	5	20	53	175W, 130H, 380L
5.0	350	5	20	79	175W, 130H, 380L

**Composition (all-weld metal mass%)**

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.47	1.00
<b>Mn</b>	1.1	0.5~2.0
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	9.0	8.5~10.5
<b>Cr</b>	23.2	21.5~23.5
<b>Mo</b>	3.2	2.5~3.5
<b>N</b>	0.17	0.08~0.20
<b>Cu</b>	0.05	0.75

Note: <sup>a</sup> Single values are maximum.

**Welding parameters (A)**

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	75~95	70~90
3.2	85~120	80~115
4.0	110~160	90~140
5.0	150~200	-

**All-weld mechanical properties**

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	667	-
<b>TS (MPa)</b>	845	690min.
<b>El on 4d (%)</b>	30	20min.
<b>IV -50°C (J)</b>	72	-