CEWELD®

4462 Ti

CATEGORY	SMAW Stick Electrodes
TYPE	Rutile basic electrode for welding duplex stainless steels
APPLICATIONS	Used for pipe work and general fabrication in the offshore oil and gas and chemical process industries. Also suitable for cladding steels to obtain corrosion resistant layers..
PROPERTIES	A Rutile basic electrode for welding austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types. 2209 has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has a high resistance to intergranular corrosion, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.
CLASSIFICATION	AWS A 5.4: E 2209-17 EN ISO 3581-A: E 22 9 3 N L R 12 DIN: W.Nr. 1.4462 DIN 8556: E 22 9 3 L R 23
SUITABLE FOR	Duplex stainless steels, 1.4462, 1.4417, 1.4582, 1.4463, 1.4460, 1.4362, 1.4583, P235GH, P265GH, S255N, P295GH, S355N UNS S31803 : UR 45N & UR 45N+, 2205, SAF 2205 Fafer 4462, NKCr22, SM22Cr, Falc 223 UNS S32304 : UR 35 N SAF 2304
APPROVALS	CE approved
WELDING POSITIONS:	

WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	N
<0.03	1.1	0.35	21-23	9-10	2.8-3.3	0.15

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm²)	Rm (N/mm²)	A5 (%)	Impact Energy (J) ISO-V 20°C	-40°C	-60°C	Hardness HRc / HV
AW	>480	>690	>25	>50			

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack	kg / 1000
2.5	300	60-90	2.5	15	
3.2	350	80-120	2.8	16.8	
4.0	350	110-170	2.8	16.8	
5.0	450		3.2	19.2	100

REDRYING TEMPERATURE	300°C/2hr (not often required).