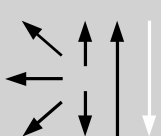


Classifications							
EN ISO 3581-A				AWS A5.4			
E 22 9 3 N L R				E2209-17			
Characteristics and typical fields of application							
<p>Primarily designed for welding 22Cr duplex stainless steels used in offshore, shipyards, chemical tankers, chemical/petrochemical, pulp &amp; paper, etc.</p> <p>Avesta 2205 is an all-position electrode of E2209-17 type. The weld metal has very good resistance to pitting and stress corrosion cracking in chloride containing environments. PREN &gt;35. Duplex alloys have good weldability, but the welding procedure should be adapted to the base material considering fluidity, joint design, heat input, etc.</p>							
Base materials							
<p>1.4462 X2CrNiMoN22-5-3, 1.4362 X2CrNiN23-4, 1.4462 X2CrNiMoN22-5-3 together with 1.4583 X10CrNiMoNb18-12, 1.4462 X2CrNiMoN22-5-3 with P235GH/ P265GH, S255N, P295GH, S355N, 16Mo3</p> <p>UNS S31803, S32205</p>							
Typical analysis of all-weld metal							
	C	Si	Mn	Cr	Ni	Mo	N
Wt.-%	0.02	0.8	0.7	22.6	9.4	3.0	0.16
Mechanical properties of all-weld metal – typical values (min. values)							
Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		Hardness	
	MPa	MPa	%	20°C	–40°C	HB	
u	620 (≥ 450)	810 (≥ 690)	25 (≥ 20)	45	35	240	
u untreated, as-welded							
Operating data							
	Polarity DC +	Electrode ID 2209-17/2205	Ø mm	L mm	Current A		
			2.5	350	45 – 80		
			3.2	350	70 – 120		
			4.0	450	90 – 160		
			5.0	450	150 – 220		
<p>Interpass temperature max. 150°C</p> <p>Heat input 0.5–2.5 kJ/mm</p> <p>Metal recovery approx. 110%.</p> <p>Scaling temperature approx. 850°C</p>							
Approvals							
TÜV (07139.), DB (30.014.20), Certified by CWB to CSA W48, CE							