

AK E2209-16

Description: AK-E2209 is an ultra-low carbon stainless steel electrode with rutile coating, Its deposited metal contains about 40% ferrite, and both the comprehensive properties of austenitic and ferritic stainless steel, excellent pitting corrosion resistance and stress corrosion resistance, the electrode has good operability, good porosity resistance, and good corrosion resistance, can be used for both AC and DC, welding process performance is good.

Application: It is suitable for welding of 22%Cr duplex stainless steels such as 00Cr22Ni5Mo3N (SUS2205) and S31803 corresponding to the petrochemical industry.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	N
Requirement	0.04	1.00	0.5-2.5	0.03	0.04	7.5-10.0	2.5-3.5	21.5-23.5	0.08-0.2
Actual Result	0.018	0.58	1.53	0.006	0.021	8.6	3.2	22.5	0.15

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥690		≥ 15	
Actual Result	780		24	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current /A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130