

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/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
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).