Standards:

EN ISO 3581-A:	E 22 9 3 N LR 32
EN 1600:	E 22 9 3 N LR23
AWS A 5.4:	E 2209 L - 16
Mat.-No.:	1.4462
Recovery:	**120%**

capilla® 2209

Product description:

Rutile-basic coated stick electrode for overlay and fusion welding of corrosion resistant Cr-Ni-Mo alloyed Duplex-steels;

The weld metal has a ferritic-austenitic structure and is very resistant against wet corrosion in chloridic and H_2S containing media.

Maximum service temperature: 300°C

Applications:

This electrode is suitable for overlay and fusion welding of similar alloyed high corrosion resistant steels

(1.4462, 1.4362)

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mo	N	Fe
Min.		**21**	**9**	**2,8**		
Max.	**0,03**	**23**	**10**	**3,3**	**0,15**	**Bal.**

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m:	690	[MPa]
Yield strength $R_{p0,2}$:	480	[MPa]
Yield strength $R_{p1,0}$:	520	[MPa]
Elongation (L=5d):	25	[%]
Impact strength (ISO-V):	50	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	300	60 – 90	=(+)~
3,25	350	80 – 120	
4,0	350	110 – 170	

also available:
find in table of content

Capilla 2209 MAG
Capilla 2209 WIG