


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA TETRA 2209-E	
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CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4:	E2209-17
EN ISO 3581-A:	E 22 9 3 N L R 3 2
Equivalent Material number:	1.4410
ASME IX Qualification	QW432 F-N° 5 QW442 A-N° 8

DESCRIPTION

- Rutile coated all positional duplex stainless steel SMAW electrode
- 22% Cr - 9% Ni - 3% Mo - 0.15% N- low carbon type
- Excellent resistance to pitting and stress corrosion cracking
- Outstanding welder appeal
- Complements Welding Alloys cored wires TETRA S 22 9 3L-G and TETRA V 22 9 3L-G

APPLICATIONS

Welding wrought, forged or cast duplex stainless steels for service in the as-welded condition
Heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels

Examples:

UNS	Material number	EN Symbol
S31803	1.4462	X2CrNiMoN 22-5-3
S32205	1.4462	
S32304	1.4362	X2CrNiN 23 4

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Mo	N	Fe
0.02	0.9	0.9	22.5	9.4	3.2	0.18	Balance

Typical ferrite level: 45 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
700	550	22	+20°C: 40 / -40°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
800	650	27	+20°C: 60 / -40°C: 40

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 350
Current [A]	50 - 75	70 - 100	90 - 150
= +	~ 70V		

Re-drying if necessary 2 – 3 hours at 250°C.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2F, 2G, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 350
Weight / box [kg]	5	5	5

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.