


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

ASME IIC SFA 5.4 / AWS A 5.4:	E2209-15
EN ISO 3581-A:	E 22 9 3 N L B 4 2
Equivalent Material Number:	1.4462
ASME IX Qualification	QW432 F-N° 5 QW442 A-N° 8

DESCRIPTION AND APPLICATIONS

- Basic coated welding electrode made on a duplex stainless steel core wire for optimum quality
- 22% Cr - 9% Ni - 3% Mo - nitrogen enhanced - low carbon type
- Recommended where the highest toughness at low temperature is required
- Suitable for the most demanding positional welding applications
- Complements Welding Alloys cored wires TETRA S/B 22 9 3L-G and TETRA V 22 9 3L-G

Examples:

UNS	Material number	EN Symbol
S31803	1.4462	X2CrNiMoN 22-5-3
S32205	1.4462	
S32304	1.4362	X2CrNiN 23 4
S32202	1.4062	
S32003		
S32101	1.4162	X2CrMnNiN 22-5-2

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Mo	N	Fe
0.03	0.9	0.45	23.0	9.5	3.0	0.15	Bal.

Typical Ferrite level: 45 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
700	550	22	+20°C: 65 / -50°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
810	60	28	+20°C: 90 / -50°C: 65

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Minimum current intensity [A]	50	60	100
Maximum current intensity [A]	80	100	150
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Re-drying: if necessary 2h at 300-350°C, maximum 3 times.

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.