

ROCKWELD 2209



Rockweld 2209 is rutile coated electrode designed for the welding of austenitic-ferritic duplex steels. The weld deposit has a ferrite content of 25-30% providing resistance to stress corrosion cracking and pitting in chloride and hydrogen sulphide environments at service temperatures up to 300°C. The electrode has good re-strike characteristics with excellent bead profile and overall ease of operation. Suitable for use on AC & DC and welding transformers with low OCV.

CLASSIFICATIONS

AWS	A5.4	E2209-16
DIN	8556	E 22 9 3 LR 23

CHEMICAL ANALYSIS

% Carbon	<0.04	% Nickel	9.000
% Silicon	0.800	% Molybdenum	3.000
% Manganese	0.900	% Nitrogen	0.100
% Chromium	22.00		

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	>760 MPa
Yield Strength	>620 MPa
Elongation on 5d	>25%
Impact Energy 20°C	>55J

PACKING DATA

(DC + or AC (OCV 50 V min))

Diameter (mm)	Current (A)	Item Number	Pack Mass (Kg)
2.50	50-80	078-094	3 x 5
3.20	70-120	078-096	3 x 5
4.00	90-150	078-098	3 x 5

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