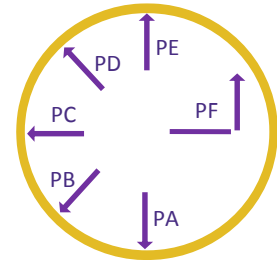


Applications

- TSS 2209 is a duplex(austenite-ferrite matrix) type stainless steel stick electrode for all position welding with its chemical composition of 22%Cr-9%Ni-3%Mo-N in the weld metal.
- Welding of duplex Stainless steel (SAF 2205, UNS S31803)

Features

- Ferritic/austenitic structure (All-weld metal)
- Service temperature up to 250°C
- High resistance to pitting, intergranular and stress corrosion
- PREN 35
- Easy to remove slag
- Good bead appearance



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	Cr	Ni	Mo	N
0.029	0.78	1.03	23.1	9.2	3.1	0.12

Typical Mechanical Properties of All-Weld Metal

TS MPa	EL (%)	Temp (°C)	CVN-Impact Value (J)
830	28.0	-20	50

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	350 (14)	350 (14)	350 (14)	350 (14)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	

Current

AC or DC ±

Redrying Condition

350°C (662°F) x 1hr

Notes on Usage

- Do not dry them twice to avoid detachment of covering.
- Keep short arc length when welding to prevent the crack and remove the slag after each welding process.
- When using AC, the electrode will become hot easily and there will be more spatter during welding process.

Packing Details

2Kg Vacuum Packing & 10Kg Ctn