



Product Data Sheet

Duplex stainless & heat resistant steels

SUPER OPTIMAL 2209-17

Classification AWS A5.4 : E2209-17 DIN ISO 3581-A : E 22 9 3 N LR 32 Werkstoff Nr: 1.4462

Description and applications Rutile type duplex stainless steel electrode for joint welding on corrosive resistant duplex-steels. Excellent resistant to intergranular corrosion, pitting and stress corrosion conditions. Low carbon content, excellent weldability, spatter free arc, very smooth bead appearance. The austenitic weld metal has a ferrite content of 40-50 %. Packed in vacuum pack system.

Material no.	Steel
1.4460	X 4 CrNiMoN 27 5 2
1.4462	X 2 CrNiMoN 22 5 3
1.4463	G-X 6 CrNiMo 24 8 2
1.4582	X 4 CrNiMoNb 25 7

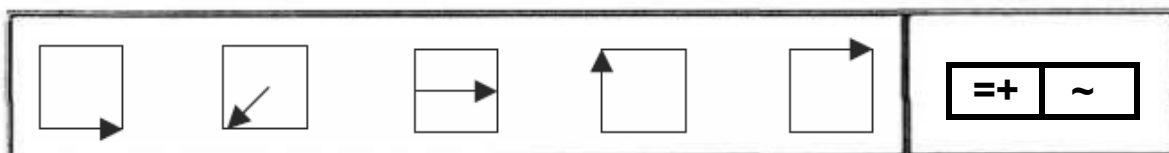
C	Mn	Si	Cr	Ni	Mo	P	S	N
0.025	0.90	0.90	22.50	9.50	3.00	0.012	0.006	0.15

Yield strength R _p (N/mm ²)	Tensile strength R _m (N/mm ²)	Elongation A ₅ (%)	Charpy Impact value (ISO-V J RT)
> 500	> 700	> 22	> 50

Dia (mm)	2.50mm	3.15mm	3.20mm	3.25mm	4.00mm	5.00mm
Amperage (A)	50 - 80	70 - 110	70-110	70- 110	100- 150	140- 190

Welding instruction Keep dry and avoid condensation. Re-drying generally not required. If necessary, re-dry electrode at 350°C for 1 hr , 3 times max.

Welding Positions



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