NC-2209 PREMIARC™

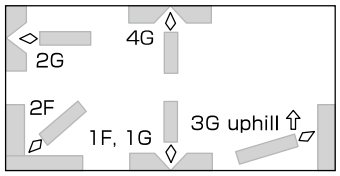
Stick electrode

Features: ▪ Suitable for normal duplex stainless steel (S32205, S31803, etc.)

Classification: AWS A5.4 E2209-16

Redrying Conditions: 250~350℃x1~2h
Identification color: -
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	20	300W, 95H, 330L
3.2	350	5	20	35	175W, 135H, 380L
4.0	350	5	20	53	175W, 130H, 380L
5.0	350	5	20	79	175W, 130H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.03	0.04
Si	0.47	1.00
Mn	1.1	0.5~2.0
P	0.02	0.04
S	<0.01	0.03
Ni	9.0	8.5~10.5
Cr	23.2	21.5~23.5
Mo	3.2	2.5~3.5
N	0.17	0.08~0.20
Cu	0.05	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	75~95	70~90
3.2	85~120	80~115
4.0	110~160	90~140
5.0	150~200	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	667	-
TS (MPa)	845	690min.
El on 4d (%)	30	20min.
IV -50℃ (J)	72	-