

# KST-2209

For duplex stainless steel (22%Cr-9%Ni-Mo)

## Classifications

EN ISO 3581-A:2012 : E 22 9 3 L R 12  
 EN ISO 3581-B:2012 : ES2209-16

AWS A5.4-06 : E2209L-16  
 JIS Z 3221 : ES2209L-16

## Description

- Covering is lime titania type for welding of 22%Cr-9%Ni-3%Mo duplex stainless steel, the principal applications are chemical plant and shipbuilding as well as nuclear plant industries. (UNS S31803)
- Excellent pitting corrosion resistance and stress corrosion cracking resistance.
- Please perform welding with selecting proper heat input according to the required mechanical properties.
- Redry the electrode at 250 - 350 °C for 30 – 60 minutes prior to use.



## Welding positions



## Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	N	PREN
0.02	0.62	0.80	0.025	0.011	8.73	22.63	3.19	0.18	35.0

## Typical mechanical properties of all-weld metal

	Y.S. (0.2%OS) (MPa)	T.S. (MPa)	El. (%)	Remarks
AWS A5.4		Min. 690	Min. 20	
EN ISO 3581-A	Min. 450	Min. 550	Min. 20	
Example	550	780	24	AW

\*AW: As-welded

## Sizes available and recommended currents ( AC or DC + )

Diameter	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amperage	F	50-80	80-110	110-150	140-180
(A)	V . OH	40-60	70-100	90-130	-

## Approvals

CE