



D&H 2209 (NS)

CODIFICATION : AWS : SFA 5.4 E2209-16
EN ISO : 3581-A E 22 9 3 N L R 3 2

CHARACTERISTICS AND APPLICATIONS :

D&H 2209(NS) is a non-synthetic electrode depositing duplex stainless steel weld metal. It is ideal for welding duplex stainless steels. The weld metal possesses excellent corrosion resistance in marine & paper environments. Suitable for welding duplex stainless steels having Cr < 25% and other grades like UNS 32205, UNS 31803, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	P	S	Cr	Ni	Mo	N
Percent	0.028	1.5	0.4	0.020	0.018	22.5	8.8	3.0	0.14

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact (J) at Minus 30°C	Hardness (RC)
723	550	25	70	24

CORROSION PROPERTY: Weld metal meets ASTM A262 Practice C, ASTM G-36, ASTM G-48A and NACE TM-01-77 specification at 350 MPa stress level, 16 bar pressure and 90°C temperature requirements in as welded condition.

FERRITE (FN) : 40-55

BEND TEST: Satisfactory with plunger diameter equal to 4 times the thickness of the specimen.

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 150-180	110-140	80-110	60-80
Weight/Carton (kgs)	: 2.5	2.5	2.5	2.5

APPROVAL: CE

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
2. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input.

Note: D&H 2209-15(NS) conforming to AWS E2209-15 is also available.