

**Standards :**

TS EN ISO 3581 - A	:	E 22 9 3 N LB 22
EN ISO 3581 - A	:	E 22 9 3 N LB 22
AWS A5.4	:	E 2209 - 15

**Chemical Composition of Weld Metal-  
% (Typical) :**

C	Si	Mn	Mo	Ni	Cr	N
0.03	0.40	1.30	2.6	9.0	22.0	0.14

**Mechanical Properties :**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength		Elongation (L <sub>0</sub> =5d <sub>0</sub> )(%)
		(ISO-V/+20°C)	(ISO-V/-60°C)	
min. 520	690-850	min. 80 J	min. 40 J	min. 30

**Typical Base Material Grades :**

\* X2CrNiMoN22-5-3, X2CrNiMoN23-4, X2CrNiMoN22-5-3 with X2CrNiMoNb18-12, X2CrNiMoN22-5-3 with P235GH, P265GH, S255N, P295GH, S355N, 16Mo3

**Features and Applications :**

- \* Applicability in welding duplex steels.
- \* Suitability to joint- and surfacing applications of similar-type austenitic steels and cast steels.
- \* Electrode coating of basic character.
- \* Excellent weldability.
- \* Very high resistance to stress corrosion cracking and to corrosion at particularly chlorious and sulphurous media.
- \* In the liquid conditions at chemical industry, serviceability at temperatures of values up to 280 °C.
- \* Re-drying : 300 - 350 °C / min. 2 h

**Welding Positions :**



**Current Type :**

D.C.(+)

**Operating Data :**

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10"	60-80	1550
3.20 x 300	1/8 x 14"	80-110	2850
4.00 x 350	5/32 x 14"	110-140	5060

**Approvals :**

TSE, CE, GOST-R, SEPRO