



Selectarc Inox 2308B

Basic Coated Electrode
For Duplex Stainless Steels

Classification

AWS A 5.4 : "E2209-15"

ISO 3581-A: E 22 9 3 N L B 42

Description & Applications

Basic coated electrode with an austenitic-ferritic microstructure (duplex). The weld deposit is characterized by a high resistance against pitting, crevice and stress corrosion in chloride containing media, like sea water, combined with a very high tensile strength. The weld metal can be applied for operation temperatures up to 250°C. The main application is for welding of steels and castings with an austenitic- ferritic structure of a similar composition.

Easy to weld with, stable arc, easy to remove slag, regular weld beads.

Main applications: For welding of casted parts which require high ferrite (ferrite according to WRC 92 > 35FN).

Base materials:

UNS	Alloy	EN 10088	Material N°
S32900	329	X3CrNiMoN27-5-2	1.4460
		G-X6CrNiMo24-8-2	1.4463
J92205		GX2CrNiMoN22-5-3	1.4470

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	N	Cu	Fe	FN
0.03	0.5	1.0	23.2	8.60	3.0	0.1	0.5	Rem.	45

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)
620	810	25

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	50-75	70-100	90-150

Redrying 2-3h at 250-300°C. Guide electrodes with a slight declination and weld with a short arc. Respect an interpass temperature of <150°C.

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