USA 2209-16
Coated Electrode

ALLOY DESCRIPTION AND APPLICATION;
USA 2209-16 duplex stainless steel electrodes are used to weld 22% chromium duplex stainless steel such as 2205, 2209, 2304 and other proprietary duplex stainless steels. It has a smooth running arc that deposits very high tensile strength, with resistance to stress, corrosion, cracking and pitting. These all-position rods have easy strike and re-strike with spatter-free arc, self-releasing slag leaving a smooth bead appearance. 2209 may also be a good choice when welding Duplex stainless such as 2553 to carbon steels or other grades of stainless.

TYPICAL WELDING PROCEDURES; DCEP & AC
<table>
<thead>
<tr>
<th>Diameter</th>
<th>Amps</th>
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<tbody>
<tr>
<td>3/32”</td>
<td>60-75</td>
</tr>
<tr>
<td>1/8”</td>
<td>90-110</td>
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<tr>
<td>5/32”</td>
<td>110-150</td>
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Procedures may vary with change in position, base metals, filler metals, equipment and other changes. When welding vertical reduce amperage 10-20%

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES
- Carbon 0.04
- Molybdenum 2.50-3.50
- Manganese 0.50-2.0
- Phosphorus 0.04
- Silicon 0.90
- Sulfur 0.03
- Chromium 21.50-23.50
- Nitrogen 0.08-0.20
- Nickel 8.50-10.50
- Copper 0.75
- Elongation 25%
- Yield Strength (psi) 87,000
- Tensile Strength (psi) 109,000

Iron balance and all single values are maximum percentages

AVAILABLE SIZES: TF 2209-16 = 3/32”, 1.8”, 5/32”

SPECIFICATIONS; ANSI/AWS A5.4 E2209-16
ASME SFA 5.4 E2209-16

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