Selectarc WELDING

SELECTARC Inox 2308B

Basic Coated Electrode for Duplex Stainless Steel

Classification

AWS A5.4 : ~ E2209 - 15 ISO 3581-A : E 22 9 3 N L B 42

Characteristics

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 service temperature upto 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. Uniform weld beads.

Applications

For welding and repair of Casted parts which require high ferrite (ferrite according to WRC 92 > 35FN), Valves.

Base Materials

UNS	ALLOY	EN 10088	Material N°
S32900	329	X3CrNiMoN 27-5-2	1.4460
		G-X6CrNiMo 24-8-2	1.4463
		G-X8CrNiN 26-7	1.4347

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	N	Cu	S	P	Fe
0.03	0.50	1.00	23.20	8.60	3.00	0.14	0.50	0.005	0.022	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R_m (MPa)	YS $R_{p0.2}$ (MPa)	% Elg A_5	Impact (KV) Temp.°C	J	FN (WRC)
AW	810	620	25	- 40	35	50

Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 300	3.2 x 350	4.0 x 350
Current	(A)	50 - 75	70 - 100	90 - 150

Redrying of electrode for 2-3 hrs at 250-300°C. Guide electrodes with a slight inclined angle and weld with a short arc. Maintain Interpass temperature : < 150°C.



1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

= +	~ 70V

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