

Duplex stainless & heat resistant steels

STARBLAZE PRIME 2209

Classification **AWS A5.4** : E2209-16 **DIN EN ISO 3581-A** : E 22 9 3 N LR 12 **Werkstoff Nr:** 1.4462

Description and applications Rutile-basic coated 22-9-3-N type Non synthetic electrode for joint welding on corrosive resistant duplex-steels. Excellent resistant to intergranular corrosion, pitting and stress corrosion conditions. Low carbon content, excellent weldability, spatter free arc, very smooth bead appearance. The austenitic weld metal has a ferrite content of 40-45 %. Packed in vacuum packed system.

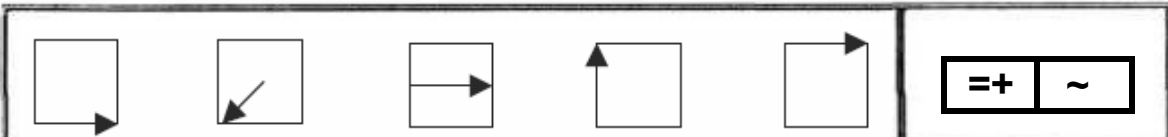
Material no.	Steel
1.4460	X 4 CrNiMoN 27 5 2
1.4462	X 2 CrNiMoN 22 5 3
1.4463	G-X 6 CrNiMo 24 8 2
1.4582	X 4 CrNiMoNb 25 7

Typical weld metal Chemical Composition (%)	C	Mn	Si	Cr	Ni	Mo	P	S	N
	0.025	0.90	0.85	22.50	9.50	3.00	0.012	0.006	0.14

All weld metal Mechanical properties (Typical)	Yield strength $R_p(N/mm^2)$	Tensile strength $R_m(N/mm^2)$	Elongation $A_5 (%)$	Charpy Impact value (ISO-V J RT)
	≥ 500	≥ 720	≥ 25	≥ 50

Amperes (A)	Dia (mm)	2.50mm	3.15mm	4.00mm	5.00mm
	Amperage (A)	50 - 80	70 - 110	100- 150	140- 190

Welding instruction Keep dry and avoid condensation. Re-drying generally not required. If necessary, re-dry electrode at 350°C for 1 hr , 3 times max.

Welding Positions	
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Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

Plant 1: A-125, Okhla Industrial Area, Phase 2, New Delhi - 110020

Corporate Office & Plant 2: 552, Pace City II, Sector 37, Gurugram, Haryana - 122001

Plant 3: B-100, Mayapuri Industrial Area, Phase-1, Near Police Station, New Delhi-110064

Plant 4: A-334, RIICO Industrial Area, Karoli, Bhiwadi, Rajasthan - 301707

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