

MIDALLOY CHROMAX E2209-16 COATED ELECTRODE

CLASSIFICATION

- AWS/SFA 5.4 Class E2209-16 / ASME SFA 5.4 Class E2209-16 / ASME Sec. IX, F5, A8

DESCRIPTION

- MIDALLOY CHROMAX E2209-16 is an all-position coated electrode used to weld standard duplex stainless steels such as UNS S31803.
- This product over-matches the base metal by 2-3% in nickel content, so as to give the correct balance of austenite and ferrite in the microstructure in the as-welded condition.
- This product will run on alternating or direct current.

APPLICATION

- MIDALLOY CHROMAX E2209-16 is used for pipe work and general fabrication in the offshore oil, gas, and chemical process industries.
- Alloy offers high strength with good ductility and excellent corrosion resistance.
- Can be used to weld duplex to carbon and to austenitic stainless if high ferrite if OK.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
.03	22.5	9.0	3.0	0.95	0.4	.02	.010	.23	.115

FERRITE CONTENT: 25% to 55%

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	120,000 PSI
YIELD STRENGTH	95,000 PSI
ELONGATION	26%

RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32"	70-85	65-75
1/8"	85-110	80-90
5/32	110-140	100-120
3/16"	120-160	110-130

STANDARD PACKAGING

- 3/32" – 8 lb. Can, 48 lb. Carton
- 1/8", 5/32", 3/16" – 10 lb. Can, 60 lb. Carton

4/22/2010

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