



BETANOX 4462

STAINLESS STEEL (Duplex SS)

AWS A/SFA 5.4 **E2209-16**

CLASSIFICATION:

ISO 3581-A
E 22 9 3 N L R 22

IS 5206
E 22.9.3 LR23

KEY FEATURES:

- Rutile type non synthetic coating
- Austenitic-ferritic type weld deposit
- Excellent combination of high strength and resistance to chloride induced SCC and pitting
- Can be applied for operating temperature upto 200°C
- Suitable for all position
- Uniform and fine ripples
- Radiographic quality weld

APPROVALS: IBR/CE

TYPICAL APPLICATIONS:

- Welding of 2205, 2209 type duplex stainless steels and similar composition
- Pipelines transporting chloride bearing products and sour gases
- Cladding on carbon and low alloy steels
- Cast pumps, Valve bodies and sea water handling equipment
- For chemical equipments, heat exchangers, off-shore platforms
- Suitable for materials 1.4417, 1.4460, 1.4462, 1.4362, 1.4162

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


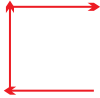
C	Mn	Si	Cr	Ni	Mo	N
0.03	0.9	0.5	22.5	8.9	3.2	0.15

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	CVN Impact, at -40°C, J	Ferrite No.
Typical	As Welded	735	25	50	32
Specification		690 min	20 min	47 min	30-55

PREN: 35 min

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A 50-75 80-100 110-140	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 2209	Tiginox 2209	Miginox FC 2209	Automelt S33	Subinox 2209