



BETANOX 4462

STAINLESS STEEL (Duplex SS)



Duplex stainless steel Electrode for high strength and pitting resistance

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

E 22 9 3 N L R 22

E 2209-16

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

WELDING POSITION :



DCEP

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

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	N	S	P	Cu
Typical	0.03	1.3	0.5	22.0	9.2	2.9	0.15	0.02	0.02	-
Specification	0.04 max	0.5-2.0	1.00 max	21.5-23.5	8.5-10.5	2.5-3.5	0.08-0.20	0.03 max	0.04 max	0.75 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	CVN Impact, at -40°C, J	Ferrite No.	PREN
Typical	As Welded	735	25	50	32	42
Specification		690 min	20 min	40 min	30-35	35 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	50-70	2	5	10
2.5 x 350	70-90	2	5	10
3.15 x 350	90-140	2	5	10
4.0 x 350	140-180	2	5	10

EQUIVALENT : GMAW wire: Miginox 2209 GTAW filler: Tiginox 2209 FCAW wire: Miginox FC 2209