

SUPRANOX RS 22 9 3 N is a rutile coated MMA electrode with PREN > 32 particularly suitable for welding duplex stainless steels 22%Cr,9%Ni,3%Mo. High resistance to intergranular corrosion, pitting and stress corrosion conditions.

Structural with Duplex for corrosion resistance as paper Industry, Tankers. WR 4462, URANUS 45N, UNS 31803. Good weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance.

Electrode for welding Duplex 2209 steels. Excellent inter-granular corrosion resistance.

Classification	
EN ISO	3581-A: E 22 9 3 N L R 12
AWS	A5.4: E 2209-16

Approvals	Grade
BV	2209
DNV	DUPLEX
RINA	2209

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	N	Ferrite
0.025	0.9	0.9	≤ 0.03	≤ 0.03	22.5	9.5	2.8	0.14	30-55

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 450	≥ 690	≥ 20	≥ 47

Materials

UNS S31803 - S31500 - S31200 - S32304

1.4462 (X2CrNiMoN22-5-3)

Storage

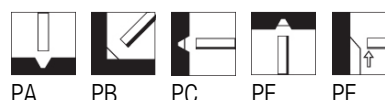
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 250-300°C for 1 hour, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.5	300	35-70	18.9			90	W000287892
3.2	350	60-120	37.6	120	W000287889	55	W000287889
4.0	350	90-140	55.0	85	W000287890	85	W000287890