



Cromarod Duplex LP

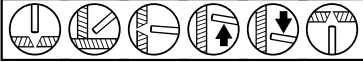
SMAW - (Stick) - MMA
Stainless Steel

Date: 2009-02-27
Revision: 13

Description:

Cromarod Duplex LP is a fully positional rutile flux coated electrode designed specially for pipe-welding. It has a thin coating and fast-freezing slag, making it ideal for root runs. The electrode is intended for welding similar composition duplex stainless steels, e.g. 1.4462, UNS 31803. With thicker walled pipe it can be advantageous to use Cromarod Duplex LP for the root plus first passes and then continue with ordinary Cromarod Duplex.

Welding positions:



Coating type:

Rutile

Welding current:

DC +, AC 0CV > 39V

Ferrite content:

FN 35 (WRC-92)

Corrosion resistance

Typical value: PRE 35
CPT 30 °C (ASTM G48)

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,6	0,5			21,0	7,5
Typical	0,02	1,0	0,8	0,02	0,02	23,2	9,2
Max	0,040	1,2	2,0	0,030	0,025	24,0	10,5

	Mo	Cu	V	Nb	N
Min	2,5				0,13
Typical	3,0				0,16
Max	4,0	0,5	0,1	0,1	0,20

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 480 MPa	680 MPa
Tensile Strength, Rm:	≥ 690 MPa	800 MPa
Elongation, A5	≥ 24%	25%
Impact energy, CV:	-46 °C • ≥ 27 J	-46 °C • 32 J

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,0	300	74592000	20-45	21	0,67	145	0,7	40
2,5	300	74592500	35-85	22	0,75	80	1,0	38
3,2	350	74593200	50-110	22	0,71	44	1,2	62

Classification:

EN 1600	E 22 9 3 N L R 12
AWS A5.4	~E 2209-17
ISO 3581-A	E 22 9 3 N L R 12

Approvals:

CE

Note

AWS: Slight difference in Cr and Si.

Core wire:

P ≤ 0.020%

S ≤ 0.010%

0.14% ≤ N ≤ 0.17%