Cromarod Duplex B

SMAW - (Stick) - MMA

Stainless Steel

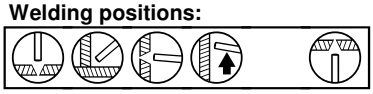
Date: 2009-02-27
Revision: 9

Description:
Cromarod Duplex B is a basic flux coated electrode intended for welding similar composition duplex stainless steels e.g. 1.4462, UNS 31803. The basic coating design produces a very low micro-oxide level in the deposit, giving excellent fracture toughness at temperatures down to -46 °C.
Duplex stainless steels offer an excellent combination of high strength and very good resistance to chloride induced pitting and stress corrosion cracking.

A heat input range of 0,5-2,5 kJ/mm is recommended to maintain a favourable ferrite/austenite phase balance in the weld metal.

Applications:
Offshore, platform, pipework, pipelines transporting chloride bearing products, or sour gas and process vessels for chloride environments.

Welding positions:



Coating type:
Basic

Welding current:
DC +

Ferrite content:
FN 35 (WRC-92)

Corrosion resistance
Typical value: PRE 36
CPT 30°C (ASTM G48)

Metal recovery:
110%

Redrying temperature:
350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,3	0,5			22,5	8,5
Typical	0,03	0,6	0,9	0,020	0,010	23,0	9,0
Max	0,04	0,90	2,0	0,030	0,020	23,5	10,0

	Mo	Cu	V	Nb	N
Min	3,0				0,15
Typical	3,2				0,17
Max	3,5	0,3	0,1	0,1	0,20

Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:	≥ 450 MPa	630 MPa
Tensile Strength, Rm:	≥ 690 MPa	790 MPa
Elongation, A5	≥ 20%	27%
Impact energy, CV:	-50 °C • ≥ 47 J	-40 °C • 65 J
		-50 °C • 60 J

Classification:

EN 1600	E 22 9 3 NL B 42
AWS A5.4	E 2209-15
ISO 3581-A	E 22 9 3 NL B 42

Approvals:
CE

Note
Core wire:
P ≤ 0.020%
S ≤ 0.010%
0.14% ≤ N ≤ 0.17%

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.)
2,5	300	74622500	50-80	24	0,65	87	0,8	44
3,2	350	74623200	75-120	25	0,68	43	1,4	54
4,0	350	74624000	120-175	27	0,68	28	1,9	59