GWELD
SEAL OF TRUST

GRIBINOX 2209

IDENTIFICATION
GRIBINOX 2209 E 2209-15

CLASSIFICATION
AWS/SFA 5.4:E2209-15,
DIN 8556-86 E2293LB26 EN 1600-97 E2293NLB12

DESCRIPTION
A basic coated electrode which deposits a 23% Cr/ 9 % Ni / 3 % Mo / 0.15 % N austenitic-ferritic duplex stainless steel weld metal having a ferrite content of about FN45. The electrode is designed for welding similar composition duplex stainless steels which 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 phase balance. The electrode deposits X-ray quality welds.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	N	Cu	Mo	S	P
0.04 max	0.5 - 2.0	0.35 - 0.70	21.5 - 23.5	8.5 - 10.5	0.10 - 0.20	0.50 max	2.50 - 3.50	0.025 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
700 - 800	20 - 25	**Temp**	**Joules**
		0°C	50 - 80

TYPICAL APPLICATIONS
- Off-shore platform pipe work, pipelines transporting chloride bearing products or sour gas and process vessels for chlorine environments.
- ASTM A 182 Gr. F 51
- USN S 31803
- DIN 1.4462
- Chemical and petrochemical process industries.

MICROSTRUCTURE : As welded condition contain about 30-50 FN (depends upon dilution, heat input etc.)
PITTING RESISTANCE EQUIVALENT : PRE more than 34
ASME IX QUALIFICATION : QW-432 F-NUMBER 5, QW-442 A-NUMBER 8
REDRYING : 300°C / 2 hrs, max 5 cycles, 10 hrs total

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 90	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	80 - 120	2 x 5 = 10	60 x 5 = 300
4	350	130 - 170	2 x 5 = 10	38 x 5 = 190
5	350	160 - 200	2 x 5 = 10	24 x 5 = 120