

GRINOX 2209

IDENTIFICATION

GRINOX 2209 E 2209-16

CLASSIFICATION

AWS/SFA 5.4:E2209-16 ,
DIN 8556-86 E2293LR26 EN 1600-97 E2293NLR12

DESCRIPTION

Rutile coated electrode with authentic and ferritic microstructure. The weld metal is resistance to chloride contents media like sea water against petting corrosion as well as crevice and stress corrosion. While welding it is necessary to control heat input which should not be too less too high. Deposited weld are of Radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	N	Cu	Mo	S	P
0.04 max	5.0 - 2.0	0.35-0.90	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	
		Temp	Joules
700 - 800	20 - 25	20°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 AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
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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