

**Standards**

TS EN ISO 3581-A	: E 22 9 3 N L R 32
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AWS A5.4	: E 2209 - 17

**Chemical Composition of  
Weld Metal % (Typical)**

C	Si	Mn	Mo	Ni	Cr	N
0.03	0.5	0.9	2.7	10.0	22.0	0.12

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 520	690-850	min. 47 J	min. 20

**Typical Base Material Grades**

- X2CrNiMoN22-5-3, X2CrNiMoN23-4, X2CrNiMoN22-5-3 with X2CrNiMoNb18-12, X2CrNiMoN22-5-3 with P235GH/ P265GH, S255N, P295GH, S355N, 16Mo3

**Features and Applications**

- Applicability in welding duplex steels
- Suitability to joint- and surfacing applications of similar-type austenitic steels and cast steels
- Electrode coating of rutile character
- Excellent weldability
- Very high resistance to stress corrosion cracking and to corrosion at particularly chlorious and sulphurous media
- In the liquid conditions at chemical industry, serviceability at temperatures of values up to 280°C
- Re-drying: 250°C - 300°C / min. 2h

**Welding Positions**

**Current Type**

D.C.(+) / A.C.

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101533	2.50 x 250	3/32 x 10"	50 - 90	1410
3010101538	3.20 x 350	1/8 x 14"	80 - 120	3540
3010101543	4.00 x 350	5/32 x 14"	110 - 160	5200

**Approvals:** TSE, CE, ABS, BV, Class NK, SEPRO, RINA