

Avesta 2205 basic

Stick electrode

Classifications

high-alloyed

EN ISO 3581-A:

AWS 5.4:

E 22 9 3 N L B

E2209-15

Characteristics and field of use

Avesta 2205 basic provides better impact properties and somewhat better position welding properties compared to the 3D type. It is primarily designed for welding duplex steels of the 2205 type. The weldability of duplex steels is excellent, but the welding should be adapted to the base material, considering fluidity, joint design, heat input etc.

Base materials

For welding steels such as					
Outokumpu	EN	ASTM	BS	NF	SS
2205	1.4462	S32205	318S13	Z3 CND 22-05 Az	2377

Typical analysis of all-weld metal (Wt-%)

C	Si	Mn	Cr	Ni	Mo	N
0.03	0.5	1.2	23.5	8.9	3.0	0.16

Ferrite 45 FN WRC-92

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation ($L_0=5d_0$)	Impact values in J CVN	
	MPa	MPa	%	+20°C:	-40°C:
untreated	645	840	26	90	75

Operating data

Polarity = + / ~

Dimensions (mm)**Amperage A**

2.5	45-75
3.25	70-110
4.0	100-140