

Avesta 2205-PW AC/DC

Stick electrode

Classifications

high-alloyed

EN ISO 3581-A:

AWS A5.4:

E 22 9 3 N L R

E2209-17

Characteristics and field of use

Avesta 2205-PW is a duplex electrode with a coating optimized for the vertical-up and overhead position welding of duplex 2205 type steel. The weldability of duplex steels is excellent, but the welding should be adapted to the base material, considering fluidity, joint design, heat input etc. Thanks to the sharp and concentrated arc, PW electrodes are extremely suitable for maintenance and repair welding, especially when joint surfaces are not particularly clean.

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
0.02	0.8	0.8	23.0	9.5	3.1	0.18

Ferrite 35 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:	-46°C:
untreated	680	860	25	55	35

Operating data

Polarity = + / ~

*Dimensions (mm)**Amperage A*

2.5	50-80
3.25	70-110
4.0	100 - 160
5.0	160 - 220