

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 is primarily designed for welding duplex stainless steels such as 2205. 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
0.02	0.8	0.7	22.6	9.4	3.0	0.16

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	635	810	25	50	35

Operating data



Polarity = + / ~

Dimensions (mm)	Amperage A
2.0	30-60
2.5	45-80
3.25	70-120
4.0	90-160
5.0	150-220