

## MMA Electrodes Stainless and Heat resistant steels

SUPRANOX RS 22.9.3L is particularly suitable for the welding of duplex stainless steels. High resistance to intergranular corrosion, pitting and stress corrosion conditions. Low carbon content. Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance. Efficiency 100%.

Classification	
EN	1600: E 22 9 3 N L R 12
AWS	A5.4: E 2209-16

Approvals	Grade
BV	2209
DNV	DNV
RINA	2209

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	N	Ferrite
0.025	0.9	0.9	≤ 0.03	≤ 0.03	22.5	9.5	2.8	0.14	30-55

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 450	≥ 690	≥ 20	≥ 47

### Materials

UNS S31803 - S31500 - S31200 - S32304

1.4462 (X2CrNiMoN22-5-3)

### Storage

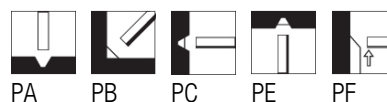
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 350-370 °C for 1 hour, 3 times max.

### Current condition and welding position

AC; DC+



### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	GASP	
				PC	Code
2.5	300	35-70	18.9	190	●
3.2	350	60-120	37.6	120	●
4.0	350	90-140	55.0	80	●
5.0	350	140-210	83.9	50	●