

EXCALIBUR® 2209-16

Stainless • AWS E2209-16



KEY FEATURES

- Designed for welding 22% Cr Duplex Stainless Steels
- The welds offer excellent resistance to stress corrosion, cracking and pitting
- High strength welds and good corrosion resistance in a range of environments

CONFORMANCES

AWS A5.4/A5.4M: 2012	E2209-16
ASME SFA A5.4:	E2209-16

TYPICAL APPLICATIONS

- Offshore
- Oil and Gas
- Chemical
- Petrochemical
- Welding 2205 Stainless Steels

WELDING POSITIONS

All, except vertical down

DIAMETERS / PACKAGING

Diameter		Length		8 lb (3.6 kg) Easy Open Can	10 lb (4.5 kg) Easy Open Can
in	(mm)	in	(mm)	24 lb (10.9 kg) Master Carton	30 lb (13.6 kg) Master Carton
3/32	(2.4)	12	(305)	ED034985	
1/8	(3.2)	14	(355)		ED034986
5/32	(4.0)	14	(355)		ED034987
3/16	(4.8)	14	(355)		ED034988

DEPOSIT COMPOSITION(1) - As Required per AWS A5.4/A5.4M: 2012

	%C	%Cr	%Ni	%Mo	%Mn	%Si
Requirements						
AWS E2209-16	0.04 max	21.5 - 23.5	8.5 - 10.5	2.5 - 3.5	0.5 - 2.0	1.0 max
Typical Results(2)	0.02	22.3	9.5	3.2	1.1	0.5 □
	%P	%S	%N	%Cu	FN	
Requirements						
AWS E2209-16	0.04 max	0.03 max	0.08 - 0.20	0.75 max	Not Required	
Typical Results(2)	0.02	0.01	0.16	0.06	30 - 60	

TYPICAL OPERATING PROCEDURES

	Current (Amps)			
Polarity(5)	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
AWS E2209-16				
DC+/AC	40 - 80	75-110	95 - 150	130 - 200