



Cromatig Duplex

GTAW - TIG
Stainless Steel

Date: 2008-01-22
Revision: 12

Description:

Cromatig Duplex deposits a 23% Cr / 9% Ni / 3% Mo / N austenitic/ferritic duplex stainless steel weld metal with a ferrite content of about FN 35. It is intended for welding similar composition Duplex stainless steels which offer an excellent combination of much higher strength and very good resistance to pitting and stress corrosion cracking, compared to standard austenitic stainless steels.

Welding current:

DC-

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,25	1,0			21,0	7,5
Typical	0,015	0,4	1,8	0,020	0,005	22,5	9,0
Max	0,03	0,80	2,0	0,030	0,020	23,5	9,5

	Mo	Cu	N
Min	2,5		0,12
Typical	3,0	0,10	0,18
Max	3,5	0,30	0,20

Shielding gas:

Acc. to EN 439:

I1, 99.99% Ar, 6-12 l/min

Stamping

Elga, AWS, Wst, EN, Batch

Ferrite content:

FN 35

Corrosion resistance

Very good resistance to pitting corrosion and stress corrosion cracking in chloride and H₂S environments. Good resistance to intergranular corrosion. Pitting resistance equivalent, PRE = 35.

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,015	0,4	1,7	0,02	0,005	22,5	9,0
Max							

	Mo	N
Min		
Typical	3,0	0,15
Max		

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 450 MPa	620 MPa
Tensile Strength, Rm:	≥ 690 MPa	800 MPa
Elongation, A5	≥ 20%	30%
Impact energy, CV:		-46°C • 100 J -60°C • 85 J

Classification:

EN ISO 14343
AWS A5.9

W 22 9 3 N L
ER2209

Approvals:

DNV

DB

TÜV

CE

Kennblatt Nr 43.042.11

Product data

Diam.mm	Length mm	Product code
1,6	1000	9816-1016
2,0	1000	9816-1020
2,4	1000	9816-1024