



LKE-2209-16

LINKWELD ALLOYS INC.

AWS A5.4 E2209-16
JIS Z3221 ES2209-16

Characteristics:

LKE-2209 is a designed to weld duplex stainless steels. With excellent pitting corrosion resistance, stress corrosion resistance and crack resistance.

Applications:

It is suitable for welding of chemical equipment, heat exchanger and pipes.

Notes on Usage:

1. Dry the electrodes at 250-300°C for 60 minutes and keep at 100-150°C before use.
2. Use lower currents and keep the arc as short as possible.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	N	Cr	Ni	Mo
0.12	0.45	0.2	0.018	0.01	0.15	23.0	8.7	3.0

Typical mechanical properties of weld metal

TS N/mm ²	EL %
785	26

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.6	3.2	4.0	4.8
Length (mm)		300	350	350	350
Amps	F	60-90	80-130	130-170	180-210
	V&OH	50-70	70-110	100-130	-
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20