

AI-0220

Specifications

AWS/ASME A5.8: E2209-17

Description and Applications

AI-0220 is a SAF 2209 covered electrode with rutile-acid coating for welding of duplex (ferritic-austenitic) stainless steels of UNS S31803/S32205 type (e.g. Sandvik SAF 2205). It is characterized by very good welding properties and gives an austenitic-ferritic chromium/nickel/molybdenum weld metal with an extremely low carbon content for service temperatures up to 250°C (480°F). Spray transfer gives a bead with a finely rippled surface. There is little spatter and very good slag removal.

Typical Weldmetal Analysis

C	Mn	Cr	Fe	Ni	Si	Mo	N
0.3	0.8	23	Bal	9	0.9	0.03	0.15

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	700MPa
Yield Strength (0.2%)	500Mpa
Elongation	40% (4d)
Charpy	48J

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	50-80
3.2	DC /AC	80-110
4.0	DC /AC	110-140

Also available as TIG: **AI-0220T** and MIG wire: **AI-17220**

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy. All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au

