

# SUPRANOX RS 22.9.3L

## MMA Electrodes Stainless and Heat resistant steels

Supranox RS 22.9.3L is particularly suitable for the welding of Duplex stainless steels. Excellent 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%. Packed in Gaspack system.

### Classification

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

### Approvals

### Grades

BV
DNV
RINA

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.025	0.90	0.90	≤ 0.030	≤ 0.030	22.50	9.50	3	-	-	0.14	30-55

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -20°C	Hardness
As Welded	≥ 450	≥ 690	≥ 20	≥ 27	-

### Materials

1.4462 (X2CrNiMoN22-5-3)

UNS S31803 - S31500 - S31200 - S32304

### Storage and redrying

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

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	35-70	18,9	11,3
3,2	350	60-120	37,6	22,5
4,0	350	90-140	55,0	33,4
5,0	350	140-210	83,9	50,3