

NOUVE[®] 2209-16

Designation

AWS/SFA-5.4: E2209-16

UNS No. W39209

Welding Positions



Features

- ▶ Excellent arc characteristics
- ▶ Low moisture re-absorption
- ▶ Low spatter level
- ▶ Low smoke level
- ▶ Quick and easy slag removal
- ▶ Radiography quality

Applications

1. Chemical Industries
2. Oil and Gas Industries
3. Petrochemical Process Plants
4. Paper and Pulp Industries
5. Structural Application

Type of Current

Direct Current Electrode Positive (DCEP)

Recommended Welding Techniques

- GENERAL : Electrode positive, work negative (DCEP)
 ARC LENGTH : Short arc
 STORAGE : Re-dry electrodes to 200°C for 1 hour before use.

Weld Metal Chemistry

WELD METAL ANALYSIS (%)	AWS SPEC	TYPICAL
Carbon (C)	0.04 max	0.036
Manganese (Mn)	0.5 – 2.0	1.27
Phosphorous (P)	0.04 max	0.032
Sulphur (S)	0.03 max	0.005
Silicon (Si)	1.0 max	0.45
Chromium (Cr)	21.5 – 23.5	22.78
Nickel (Ni)	8.5 – 10.5	8.73
Molybdenum (Mo)	2.5 – 3.5	3.381
Iron (Fe)	Remainder	61.275
Copper (Cu)	0.75	0.082
Nitrogen (N)	0.08 – 0.20	0.139

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Mechanical Properties (as welded)

MECHANICAL TESTS	AWS SPEC	TYPICAL	PREN
Tensile Strength	1,00,000 psi (690 MPa) Minimum	1,18,931 psi (820 MPa)	37 Minimum
Elongation % in 2"	20% Minimum	Above 22%	

Dimension, Current Condition & Packing Data

DIAMETER (IN)	DIAMETER (MM)	PACKAGE		CURRENT CONDITION (DC+) Amps
3/32	2.5	2 Kg	5 Kg	60 - 90
1/8	3.15	2 Kg	5 Kg	80 - 110
5/32	4.0	2 Kg	5 Kg	110 - 150
3/16	5.0	2 Kg	5 Kg	150 - 180