

Classifications

| EN ISO 14343-A | EN ISO 14343-B | ASME II C SFA 5.9 |
|----------------|----------------|-------------------|
| B Z 22 6 3 N L | BS(2209) | (EQ2209) |

Characteristics and typical fields of application

SOUDOTAPE 22.6.3L is a low carbon 22% chromium duplex stainless steel strip electrode.

SOUDOTAPE 22.6.3L strip electrode, in combination with electroslag flux RECORD EST 122, is designed to met duplex stainless steels (UNS S32205/S31803) weld overlay.

With electroslag flux RECORD EST 4462-1, this strip electrode can achieve duplex 1.4462 in single layer.

With electroslag flux RECORD ES 2209-1, this strip electrode is the best choice to met single layer weld overlay of modified duplex 22% chromium, 9% nickel and 3% molybdenum (SFA 5.39 2209).

Pitting corrosion is superior to Alloy 316L or Alloy 317L.

Highly suitable for service in environments containing chlorides and hydrogen sulfide, such as marine environments and the oil and gas extraction industry, the pulp and paper industry, and heat exchangers.

Typical analysis

| | C | Si | Mn | Cr | Ni | Mo | N | Fe | Cu |
|-------|------|-----|-----|------|-----|-----|------|------|-----|
| wt.-% | 0.02 | 0.4 | 1.5 | 22.3 | 5.7 | 3.2 | 0.17 | Rem. | 0.2 |

Typical fluxes to combine

| Process | Name | EN ISO 14174 |
|---------|-------------------|--------------|
| ESW | RECORD ES 2209 | ES A FB 2B |
| ESW | RECORD ES 2209-1 | ES A FB 2B |
| ESW | RECORD EST 122 | ES A FB 2B |
| ESW | RECORD EST 4462-1 | ES A FB 2B |
| SAW | RECORD INT 110 | S A CS 2B |

Packaging

| Size(s) in mm | Type | Weight |
|---------------|------|------------|
| 30 x 0,5 | Coil | 25 - 30 kg |
| 60 x 0,5 | Coil | 50 - 60 kg |
| 90 x 0,5 | Coil | 75 - 90 kg |

Other sizes and coil weights on request.