



Manufacturers of Custom Welding Lines for Resale  
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# SELECTRODE 1179 Duplex 2209

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 2209-17  
EN 1600: E 22 9 3 N L R 32

## FEATURES & APPLICATIONS

For welding and cladding "DUPLEX" stainless sheets and castings.

Universal "DUPLEX" electrode for welding and cladding of austenitic/ferritic microstructure stainlesses

- Nitrogen bearing weldmetal is resistant to chloride containing medias.
- High strength combined with excellent corrosion resistance.
- Excellent overall welding characteristics.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** In the as-welded condition deposits have between 30% and 50% ferrite.

**Flux Color:** Grey/tan

Mo	Ni	C	Si	P	Mn	S	Cr	Cu	Fe	N
3.0	9.0	.028	.90	.02	.90	.01	22.5	.02	bal	.18

## TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	115,000 PSI (800 MPa)
Yield Strength	94,000 PSI (650 MPa)
Elongation	25%
Impact Energy	37J: -40°C

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** AC/DC(+)

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	70	90
Maximum Amperage	80	100	150

**Welding Techniques:** Maintain low amperage and do not allow interpass temperatures to exceed 374°F (190°C).

**Welding Positions:** Flat, Horizontal, Vertical up, Overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings	Recovery Rate
3/32 (2.5)	12" (300)	.3 oz. (9g)	50 (109)	35 (76)	65	110%
1/8 (3.25)	14" (350)	.7oz (20g)	22 (49)	21 (46)	95	110%
5/32 (4.0)	14" (350)	1 oz (29g)	15 (33)	18 (40)	120	110%

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (300)	14" (350)	14" (350)
Electrodes / lb	24	12	8
Electrodes / kg	53	27	18