LEXAL E 22 9 3 N ™

MMA Electrodes

Stainless and Heat resistant steels

LEXAL E 22 9 3 N is a rutile coated MMA electrode, with homogeneous Duplex core wire, for welding ferritic-austenitic duplex stainless steels, e.g.1.4462 and UNS S31803, also for joining duplex to standard austenitic or ferritic steels. The weld metal has high-strength, toughness and good resistance to pitting, crevice and stress-corrosion cracking in media containing chlorides and hydrosulphides. Weld metal transfer is in fine droplets, good fusion of the joint faces, easy slag removal and finely rippled bead surface. Maximum operating temperature <250 °C.

Classification	
EN	1600: E 22 9 3 N L R 1 2
AWS	A5.4: ~E 2209-16

Approvals				
ABS	**BV**	**DNV**	**GL**	**LRS**
E2209	UP	DUPLEX	4462	S31803

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	Cr	Ni	Mo	N	Ferrite
All weld metal	≤0.030	1	1	22.5	9	3.2	0.15	35-50

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-40 °C
As Welded	≥ 550	≥ 690	≥ 20	≥ 50	≥ 32

Materials

UNS S31803 - S31500 - S31200 - S32304

1.4462 (X2CrNiMoN22-5-3)

Storage

Keep dry and avoid condensation.

Re-dry at 300-350 °C for 2 hours, 5 times max.

Current condition and welding position

AC; DC+

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX		DRYF	
				PC	Code	PC	Code
2.5	300	60-85	17.1	210	●	30	●
3.2	350	80-110	32.9	140	●	24	●
4.0	350	95-130	50.8	80	●	18	●