

BASINOX 22 9 3 N

TOP FEATURES

- Good weldability with a spatter free arc
- Self-releasing slag combined with a very smooth bead appearance and high level of fracture toughness at -50°C
- Excellent resistance to intergranular corrosion.

CLASSIFICATION

AWS A5.4 E2209-15
EN ISO 3581-A E 22 9 3 N L B 42

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Ni	Mo	N	Ferrite
≤0.04	1.20	0.4	≤0.020	≤0.020	23.40	9	2.80	0.15	35-50

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

MECHANICAL PROPERTIES, TYPICAL, ALL STEEL GRADES						
Condition*		0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-50°C
AWS A5.4	AW	not specified	≥690	≥20	not specified	not specified
EN ISO 3581-A	AW	≥450	≥550	≥20	not specified	not specified
Typical values	AW	550	750	28	80	45

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	70-90
3.2 x 350	95-120
4.0 x 350	130-160

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x300	VPMD	105	1.8	W100288019
3.2x350	VPMD	62	2.0	W100288020
4.0x350	VPMD	40	2.0	W100288021

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.