

LEXAL E 22 9 3N

TOP FEATURES

- 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

AWS A5.4 E2209-16*
EN ISO 3581-A E (22 9 3 N L) R 12

*Nearest classification

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

DNV	CE
+	+

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

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

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-40°C
AWS A5.4	AW	not specified	≥690	≥20	not specified	not specified
EN ISO 3581-A	AW	not specified	≥690	≥15	not specified	not specified
Typical values	AW	≥550	≥690	≥20	≥50	≥32

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	80-110
4.0 x 350	80-150

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	55	1.9	W100380228
4.0 x 350	VPMD	41	2.1	W100380229

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.