

SuperCore™ 2205

TOP FEATURES

- Metal recovery about 90%
- Excellent slag removal

TYPICAL APPLICATIONS

- Offshore manifolds
- Petrochemical industry
- Pipework systems

CLASSIFICATION

AWS A5.22	E2209T0-1/4
EN ISO 17633-A	T 22 9 3 N L R C/M 3
EN ISO 17633-B	TS2209-F C1/M21 0

CURRENT TYPE

DC+

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO ₂
C1	Active gas 100%
Flow rate	20-25 l/min

Proprietary gases may be used but argon should not exceed 85%.

Gas mixtures without oxygen additions can be helpful for optimum weld metal toughness.

APPROVALS

DNV

+

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	PRE*
Min.	--	0.5	--	--	--	21.5	8.5	2.8	--	0.08	34
Max.	0.04	2.0	1.00	0.02	0.030	24.0	10.0	4.0	0.3	0.20	38
Typical	0.03	1.2	0.7	<0.01	0.02	23	9.2	3.1	0.1	0.12	35

*PRE (pitting resistance equivalent) = Cr + 3.3Mo + 16N

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Min.	Typical
Tensile strength (MPa)	690	800
0.2% Proof strength (MPa)	480	610
Elongation (%) 4d	20	30
5d	20	26
Reduction of area (%)		36
Impact ISO-V (J) -20°C		50
-50°C		40
Hardness (HV)		270

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	15.0	SC2205-12