

Supercore™ 2205P

TOP FEATURES

- Is optimized for positional welding, both vertical up and for fixed pipework qualified in the ASME 5G or 6G welding positions (pipe typically > 150mm diameter, > 15mm wall).
- Smooth all position weldability
- Excellent slag removal

TYPICAL APPLICATIONS

- Offshore manifolds
- Petrochemical industry
- Pipework systems

CLASSIFICATION

AWS A5.22	E2209T1-1/4
EN ISO 17633-A	T 22 9 3 N L P C/M 2
EN ISO 17633-B	TS2209-F C1/M21 1

CURRENT TYPE

DC+

WELDING POSITIONS

All

SHIELDING GASES (ACC. EN ISO 14175)

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

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

Typical values as welded	Min.	Supercore 2205	Supercore 2205P
Tensile strength (MPa)	690	800	800
0.2% Proof strength (MPa)	480	610	630
Elongation (%) 4d	20	30	32
5d	20	26	29
Reduction of area (%)		36	45
Impact ISO-V (J) - 20°C		50	65
- 50°C		40	45
- 75°C			30
Hardness (HV)		270	270

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	15.0	SC2205P-12