

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

LR	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	30	32
	5d	20	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

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.