

# 2205XKS

## TOP FEATURES

- Stick electrode made on duplex stainless core wire with a special basic flux to give optimum all-positional operability
- Recovery is about 105%
- The electrode has a basic flux system and is recommended where the highest sub-zero toughness is required, and for the most demanding positional welding applications such as fixed pipework in the ASME 6G position

## TYPICAL APPLICATIONS

- Offshore oil/gas, chemical and petrochemical process industries

## CLASSIFICATION

AWS A5.4 E2209-15  
EN ISO 3581-A E 22 9 3 N L B 4 2

## CURRENT TYPE

DC+

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

ABS	DNV	TÜV
+	+	+

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

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	PREN
Min.	not specified	0.5	not specified	not specified	not specified	22.0	8.5	3.0	not specified	0.15	35
Max.	0.04	2.0	0.90	0.02	0.03	23.5	10.0	3.5	0.75	0.20	38
Typical	0.03	1	0.6	0.01	0.02	23	9	3.2	0.1	0.17	36

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded		Min.	Typical	1120 – 1135°C +WQ
Tensile strength	(MPa)	690	750-870	790
0.2% Proof strength	(MPa)	450	630-700	480
Elongation (%)	4d	20	28	41
	5d	20	26	37
Reduction of area (%)		not specified	45	64
Impact ISO-V (J)	+ 20°C	not specified	> 85	-
	- 50°C	47	> 60	> 75
	- 75°C	not specified	> 30	-
Hardness (HV)		not specified	260-290	240

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-75
3.2 x 350	65-100
4.0 x 350	80-140

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	105	1.8	2205XKS-25-2
3.2 x 350	VPMD	62	2.0	2205XKS-32-2
4.0 x 350	VPMD	40	2.0	2205XKS-40-2

2205XKS-EN-03/01/25

### 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](http://www.lincolnelectric.eu) for any updated information.