

GM DUPLEX

Classification:

AWS A/ 5.4 : E 2209 -17

Description:

GM DUPLEX is specially designed for rutile coated electrode which deposits a 23% Cr, 10% Ni, 3% Mo and 0.16% N austenitic ferrite duplex stainless weld metal having a ferrite content of about FN 35. The electrode is designed for welding of similar composition duplex stainless steels. Which offers an excellent combination of high strength and very good resistance to chloride induced pitting and stress corrosion cracking.

Applications:

- ❖ Offshore platform pipe work.
- ❖ Pipelines transporting chloride bearing products or sour gases.
- ❖ Process vessels for chloride environments.

Chemical Composition of Weld Metal (WT. %):

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.04 Max	0.5 – 2.0	0.90 Max	0.030 Max	0.040 Max	8.5 - 10.50	21.5 – 23.5	2.50 – 3.50	0.75 Max	0.08 – 0.20

Mechanical Properties of Weld Metal:

Tensile Strength (N/mm ²)	Elongation, L=4d (%)
690 Min	20 Min

Current Conditions: AC (70 V) / DC (+)

Size (mm)	2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
Current (Amps)	60 - 80	80 - 110	110 - 140	150 - 180

Welding Positions: F, H, V-up, OH

Recommendation:

Re-dry the electrodes at 250°C for 1 hour. Keep the re-dried electrodes in holding oven before use (70 to 100°C). Use electrodes within recommended current conditions for better performance.

Caution:

Protect yourself and others. Fumes & gases can be dangerous to health. Arc rays can injure eyes and burn skin. Electric shock can kill. Refer American National Standard Z49.1 "Safety in welding and cutting".

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