



# Cromarod Duplex LP

SMAW - (Stick) - MMA  
Stainless Steel

Date:	2018-09-24
Revision:	15

### Description:

Cromarod Duplex LP is a fully positional rutile flux coated electrode designed specially for pipe-welding. It has a thin coating and fast-freezing slag, making it ideal for root runs. The electrode is intended for welding similar composition duplex stainless steels, e.g. 1.4462, UNS 31803. With thicker walled pipe it can be advantageous to use Cromarod Duplex LP for the root plus first passes and then continue with ordinary Cromarod Duplex.

### Welding positions:



### Coating type:

Rutile

### Welding current:

DC+, AC OCV > 39V

### Ferrite content:

FN 35 (WRC-92)

### Corrosion resistance

Typical value: PRE 35  
CPT 30 °C (ASTM G48)

### Redrying temperature:

350 °C, 2h

### Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,6	0,5			21,0	7,5
Typical	0,02	1,0	0,8	0,02	0,02	23,2	9,2
Max	0,040	1,2	2,0	0,030	0,025	24,0	10,5

	Mo	Cu	V	Nb	N
Min	2,5				0,13
Typical	3,0				0,16
Max	4,0	0,5	0,1	0,1	0,20

### Mechanical properties

	<u>Specified</u>	<u>Typical*</u>
Yield strength, Rp0.2%:	≥ 450 MPa	680 MPa
Tensile Strength, Rm:	≥ 690 MPa	800 MPa
Elongation, A5	≥ 20%	25%
Impact energy, CV:	-46 °C • ≥ 27 J -46 °C • 32 J	

### Classification:

AWS A5.4 ~E 2209-17  
ISO 3581-A E 22 9 3 N L R 11

### Approvals:

CE

### Note

AWS: Slight difference in Cr and Si.

Core wire:

P ≤ 0.020%

S ≤ 0.010%

0.14% ≤ N ≤ 0.17%

### Product data:

Diam.mm	Length mm	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,0	300	20-45	21	0,67	145	0,7	40
2,5	300	35-85	22	0,75	80	1,0	38
3,2	350	50-110	22	0,71	44	1,2	62

\*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and ELGA AB expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the corresponding EN ISO specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by ELGA AB.

**Elga reserves the right to change specifications or approvals without prior notice.**