

Blue Max[®] LNM 4462 N

Stainless Steel • AWS ER2209

Key Features

- ▶ Q2 Lot[®] - Certificate showing actual wire composition and calculated ferrite number (FN) available online
- ▶ Available as Batch Managed Inventory
- ▶ “N” Designator - cobalt restriction of 0.05% max
- ▶ Premium performance and quality
- ▶ Designed for joining duplex stainless steels
- ▶ Provides high resistance to general corrosion, pitting and stress corrosion
- ▶ Composition is controlled to produce consistent mechanical properties
- ▶ Prior to using this material for ASME Boiler and Pressure Vessel Code Section III applications, please contact the Lincoln Electric Specials Department to receive a Certified Material Test Report (CMTR) which meet all requirements of NCA-3860.

Welding Positions

All

Typical Applications

- ▶ Nuclear power plant construction and maintenance
- ▶ Alloy 2205: UNS S31803, UNS S31500
- ▶ Alloy 2304: UNS S32304, UNS S31200
- ▶ Air pollution control systems for coal fired power plants
- ▶ Power and process industry components and piping
- ▶ Pressure Vessels

ASME IX Qualification

ASME IX Qualification: QW432 F-No 6,
QW442 A-No 8

Conformances

AWS A5.9-93: ER2209
ASME SFA-A5.9: ER2209

DIAMETERS / PACKAGING

Diameter in (mm)	33 lb (15 kg) Plastic Spool
0.035 (0.9)	ED033955
0.045 (1.2)	ED033956

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.9-93

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) @ -40°C (-40°F)
Requirements - AWS ER2209	Not Specified			
Test Results ⁽³⁾ As-Welded with 98% Ar / 2% CO ₂	625 (91)	810 (118)	28	105 (78)

WIRE COMPOSITION⁽¹⁾ – As Required per AWS Similar to AWS A5.9/A5.9M: 2006

	%C	%Cr	%Ni	%Mo	%Mn
Requirements - AWS ER2209	0.030 max.	21.5-23.5	7.5-9.5	2.5-3.5	0.5-2.0
Test Results ⁽³⁾	0.018	22.7	8.5	3.0	1.5
	%Si	%P	%S	%Cu	%N
Requirements - AWS ER2209	0.90 max.	0.03 max.	0.03 max.	0.75 max.	0.08-0.20
Test Results ⁽³⁾	0.45	0.03	0.03	0.30	0.15

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume. BEFORE USE, READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer on pg. 12. ⁽⁴⁾Copper due to any coating on the electrode plus the copper content of the filler metal itself, shall not exceed the stated 0.50% max. ⁽⁵⁾CTWD (Contact Tip to Work Distance). Subtract 1/4 in (6.4 mm) to calculate Electrical Stickout. ⁽⁶⁾Procedures in the shaded areas are procedures for short circuiting mode using 75% Argon, 25% CO₂. NOTE: For 100% CO₂ procedures, add 1 to 2 volts for short circuit transfer and 2 to 3 volts for globular transfer.