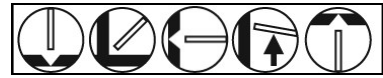


# 2209 Sterling<sup>®</sup> AP



AWS A5.4: E2209-16

WELDING POSITIONS:



**FEATURES:**

- Spray-like arc transfer
- Electrode doesn't overheat
- Directional arc
- Easy strike and re-strike
- All-position
  
- Easy slag release

**BENEFITS:**

- Low spatter and less clean-up
- Less stub loss, cost-effective
- Metal goes where directed
- Easy to use, less chance of starting defects
- Welds extremely well in flat, horizontal, vertical (up) and overhead positions
- Less chance of slag inclusions

**TYPE OF CURRENT:** Direct Current Electrode Positive (DCEP) or AC

**RECOMMENDED WELDING PROCEDURES:**

- ARC LENGTH:** Short (less than 1/2 the diameter of the electrode)
- FLAT & HORIZONTAL:** Angle electrode 10-15° from 90°
- VERTICAL-UP:** Use weaving techniques. Reduced amperage compared to flat position setting
- VERTICAL-DOWN:** Not recommended
- OVERHEAD:** Use slight weaving motion within the puddle

**STORAGE:** AC-DC electrodes have a high degree of moisture resistance; however, for critical applications, the electrodes should be held at 215°F - 300°F after opening.

**RECONDITIONING:** If exposed to atmosphere for extended periods, recondition at 660°F for 2 hours.

**TYPICAL WELD METAL PROPERTIES\* (Chem Pad):**

Weld Metal Analysis (%)		AWS Spec
Carbon (C)	0.02	0.04 max
Manganese (Mn)	0.70	0.5 to 2.5
Phosphorus (P)	0.020	0.04 max
Sulphur (S)	0.020	0.03 max
Silicon (Si)	0.90	0.90 max
Copper (Cu)	0.21	0.75 max
Chromium (Cr)	23.00	21.5 to 23.5
Nickel (Ni)	9.00	8.5 to 10.5
Molybdenum (Mo)	3.00	2.5 to 3.5
Nitrogen (N)	0.16	0.08 to 0.20

**TYPICAL MECHANICAL PROPERTIES\* (As Welded):**

Mechanical Tests		AWS Spec
Tensile Strength	122,000 psi (841 MPa)	100,000 psi
Yield Strength	97,000 psi (669 MPa)	Not required
Elongation % in 2" (50 mm)	25%	20%
DeLong Ferrite Number Range	25-80	Not required
Schaeffler Number Range	25-80	Not required
WRC Number Range (1992)	25-80	Not required

\*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.4 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 Hobart Brothers Company.

# 2209 Sterling® AP

Diameter		Weld Position	Type of Current	Amperage Range	
Inches	(mm)			Min.	Max.
3/32	(2.5)	Flat & Horizontal	DCEP or AC	60	90
1/8	(3.2)	Flat & Horizontal	DCEP or AC	80	120
5/32	(4.0)	Flat & Horizontal	DCEP or AC	130	170
3/16	(5.0)	Flat & Horizontal	DCEP or AC	160	220

- Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.

## AVAILABLE DIAMETERS AND PACKAGES:

Diameter		Length		5-Lb. Can	6-Lb. Can	7-Lb. Can
Inches	(mm)	Inches	(mm)			
3/32	(2.5)	12	(300)	S486431-036	—	—
1/8	(3.2)	14	(350)	—	S486444-032	—
5/32	(4.0)	14	(350)	—	S486451-032	—
3/16	(5.0)	14	(350)	—	—	S486458-039

## CONFORMANCES AND APPROVALS:

- AWS A5.4, Class E2209-16
- ASME SFA 5.4

**TECHNICAL QUESTIONS?** For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at [Applications.Engineering@hobartbrothers.com](mailto:Applications.Engineering@hobartbrothers.com)

### CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at [www.aws.org](http://www.aws.org)); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at [www.hobartbrothers.com](http://www.hobartbrothers.com).

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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Revision Date: 160606 (Replaces 160216)

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