Engineered for superior welding performance, the **Xuper 2233N Welding Electrodes** by **Metals And Welding Specialities** represent precision, reliability, and metallurgical excellence. These premium electrodes are designed to deliver exceptional weld quality on duplex and super duplex stainless steels where high strength, corrosion resistance, and toughness are critical. Manufactured to meet stringent industry standards, the Xuper 2233N electrodes ensure consistent results even under demanding fabrication and repair conditions.

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The **Xuper 22*33N** electrodes conform to **UNS S32750** and are equivalent to **ASTM A182 Grade F53**, recognized under the **Universal Standard – ISO 14343-A: W 25 9 4 N L**. This unique combination of chemistry and coating formulation offers outstanding performance in chloride-bearing environments, making them ideal for use in the offshore, petrochemical, pulp and paper, and desalination industries. The high alloy composition provides superior resistance to pitting, crevice, and stress corrosion cracking, ensuring dependable service in both fresh and seawater applications.

Xuper 22*33N Welding Electrodes, Xuper 22*33N Welding Electrodes Manufacturers, Xuper 22*33N Welding Electrodes Suppliers, Xuper 22*33N Welding Electrodes Stockists, Xuper 22*33N Welding Electrodes Exporters

Developed using advanced coating technology, **Xuper 22*33N Welding Electrodes** produce a stable arc with minimal spatter and excellent slag detachability. The weld deposit achieves a balanced microstructure of austenite and ferrite, which provides optimum mechanical strength and resistance to localized corrosion. These electrodes also exhibit excellent weld bead appearance and wetting characteristics, reducing post-weld finishing time. Whether used for joining, overlaying, or repair welding, they ensure consistent metallurgical integrity across all welding positions.

The electrodes are designed for use with both AC and DC current, allowing flexibility across various welding setups. The carefully formulated flux coating enhances arc stability, improves weld pool control, and minimizes the risk of porosity, even when welding in challenging conditions. This makes **Metals And Welding Specialities' Xuper 22*33N** a preferred choice among professionals seeking unmatched performance and reliability in stainless steel fabrication.

Xuper 22*33N Welding Electrodes in India, Xuper 22*33N Welding Electrodes Manufacturers in India, Xuper 22*33N Welding Electrodes Suppliers in India, Xuper 22*33N Welding Electrodes Stockists in India, Xuper 22*33N Welding Electrodes Exporters in India

When quality and precision matter, **Metals And Welding Specialities** delivers solutions that stand the test of time. Each batch of Xuper 22*33N Welding Electrodes undergoes rigorous quality inspection and metallurgical analysis to ensure compliance with global standards such as AWS A5.4 E2594-16. The result is a robust electrode capable of maintaining weld integrity in the most corrosive and mechanically demanding environments. With long-standing expertise in welding consumables, the company continues to support industries worldwide with products that combine innovation, performance, and value.

If your operations demand exceptional corrosion resistance, high tensile strength, and dependable weldability, the **Xuper 22*33N Welding Electrodes** from **Metals And Welding Specialities** provide the perfect solution for your critical applications.

Specification Xuper 22*33N Welding Electrodes

Property	Specification
Product name / Trade name	Xuper 22*33N (Xuper 2233N)
Type / Classification	Flux-coated, cored nickel-iron stick electrode (SMAW) for cast iron and cast iron to steel
Typical applications	Repair welding and joining of gray, nodular (ductile) and spheroidal graphite cast irons; cast iron to steel; pump housings, gearboxes, machine bases, transmission housings, valve bodies
Welding positions	All positions
Recommended current / polarity	AC or DC reverse polarity (DC+ recommended for many applications)

Recommended diameters (mm)	2.5 mm, 3.15 mm (3.2 mm), 4.0 mm
Typical amperage ranges	2.5 mm: 70–100 A; 3.2 mm: 90–120 A; 4.0 mm: 120–160 A
Tensile strength	~72,000 psi (≈497 MPa)
Yield strength (typical)	~58,000 psi (where specified)
Elongation	~15%
Deposit characteristics	Dense, crack-resistant deposits with excellent machinability; smooth stable arc, minimal spatter
Core / deposit chemistry	Nickel-iron based deposit (nickel-rich formulation for cast iron compatibility and machinability)
Packaging / storage	Dry-Pak or sealed containers to maintain dryness; typical commercial pack sizes vary by supplier
Standard lengths	Commonly 350–450 mm (supplier dependent)
Manufacturer / common brand	Eutectic / Castolin (marketed as Xuper 2233N)

Xuper 22*33N Welding Electrodes Parameters

Parameter	Value
Product Name	Xuper 22*33N Welding Electrodes
Electrode Type	Coated / Manual Metal Arc (MMA)
Typical Classification	Manufacturer-specific (equivalent performance to common low-hydrogen/basic Welding Electrodes)
Available Diameters	2.5 mm, 3.2 mm, 4.0 mm
Recommended Current Range	2.5 mm: 60–90 A; 3.2 mm: 90–140 A; 4.0 mm: 140–200 A
Coating Type	Basic / low-hydrogen style coated flux
Polarity	DC+ (electrode positive) recommended; AC usable depending on power source
Operating Positions	All positions (flat, horizontal, vertical, overhead) — position-dependent technique advised
Deposit Tensile Strength (typical)	Approx. 520–620 MPa
Elongation (A%)	Approx. 20–26%
Charpy Impact (where applicable)	Values depend on classification; often available for −20°C to −40°C impact testing
Yield / Deposition Efficiency	Typical deposition efficiency: 70–85%
Typical Deposit Chemistry (representative)	C ≤ 0.12%, Mn 0.7–1.5%, Si 0.2–0.8% (exact composition per manufacturer)
Usable Base Metals	Carbon steels, low-alloy steels, general structural steels
Preheat / Interpass	Depends on base metal and thickness; common practice: no preheat for thin sections; 50–200°C for thicker or higher-hardness steels

Storage	Store in dry conditions; maintain recommended storage temperature/humidity; re-dry per manufacturer's instructions if necessary
Packaging	Sealed tubs / boxes (typical weights: 2.5 kg, 5 kg, 10 kg)
Typical Applications	General fabrication, structural welding, pressure parts (as specified), maintenance and repair
Surface Appearance of Weld	Smooth ripple, easy slag removal, good bead profile
Slag Characteristics	Stable slag, easy detachment
Flux Residue	Non-corrosive when removed; remove slag between passes
Safety / Handling	Follow standard welding safety: ventilation, PPE, fume extraction

People Also Searched

UNS S32750 welding electrodes, ASTM A182 F53 electrodes, duplex stainless steel welding rods, super duplex welding electrodes, ISO 14343-A W 25 9 4 N L, AWS A5.4 E2594-16, duplex steel filler metal, high corrosion resistant electrodes, 22Cr duplex welding rod, S32750 welding consumables, stainless steel overlay electrodes, ferritic-austenitic welding rods, chloride resistant electrodes, offshore welding electrodes, petrochemical welding consumables, super duplex SMAW electrodes, duplex pipe welding rods, desalination plant welding materials, chemical plant repair electrodes, duplex steel joining electrodes, Xuper duplex electrodes, welding rods for seawater applications, corrosion resistant filler metal, duplex stainless repair rods, S32750 flux-coated electrodes, duplex steel electrode suppliers, F53 grade welding electrodes, duplex fabrication electrodes, duplex heat exchanger welding rods, duplex tank welding electrodes, duplex stainless electrodes India, stainless electrode manufacturers, duplex corrosion resistant weld consumables, high tensile duplex electrodes, duplex stainless maintenance welding rods, super duplex corrosion electrodes, duplex overlay rods, F53 UNS S32750 filler wire equivalent, Xuper 22*33N electrode specifications.