ROYAL D2MoL MOD(AWS:SFA 5.4, E 309 L Mo - 17)

AWS : SFA 5.4, E 309 L Mo - 17 EN ISO 3581 A E 22 12 2 LR 12

Applications

Suitable for welding steel containing 22 - 26% Cr, 11 - 14 % Ni, 2 - 3% Mo, also for joints between 18 Cr, - 8 Ni, stainless steel and mild steel, or low alloy steel as well as clad steel.

Characteristics on Usage

A low carbon stainless steel electrode for welding heat resistant Cr and Cr - Ni alloyed steel. It is a medium heavy coated rutile type, all position electrode yielding 25 Cr, 12 Ni, 2 Mo stainless steel weld deposit. The ferritic austenitic weld metal is very crack resistant smooth weld with clean edges. Suitable for welding build up turbine runners made of ferritic chromium stainless steel specially designed for welding root run in clad steel as well as mild steel.

Notes On Usage

- Dry the electrodes at 350°C for 60 minute before use
- Keep the arc as short as possible.
- Use currents as low as possible to avoid excessive dilution.

Welding Positions

1G 2F 3G 4G

Packing

Vaccum packing

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%
0.040 Max	0.50-2.50	1.0 Max	0.030 Max	0.040 Max	22.0-25.0	12.0-14.0	2.0 - 3.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm^2)	ELONGATION (L = 4d) %
520 Min	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC/DC (+)	45-85
3.15 x 350	2	10		85-115
4.00 x 350	2	10		100-140
5.00 x 350	2	10		135-180