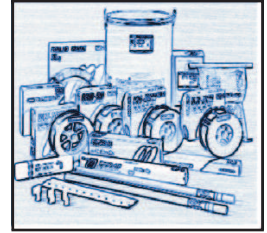


# ANU BOND D2 (E 309-16)

**Classification :** ASME / AWS A 5.4, E 309-16  
IS : 5206 E 23, 12 R 26



**Features :** This is normal carbon 25/12 stainless steel electrode. Cracking Resistance upto 1100 degree centigrades. Used for welding grades AISI 309 grade of stainless steel & Straight chrome steel for joining clad steel low alloy steel & carbon steel .

**Redrying Conditions:** 300~350 x 1 hrs

■ **Chemical composition of all-weld metal (%) as per AWS**

	C	Si	Mn	P	S	Cr	Ni
Typical	0.15	1.00	0.5 - 2.50	0.040	0.030	22.0	12.0
Example	0.05~0.12	0.15~0.45	0.25~0.65	0.030 .0.025	-	22.0-25.0	12.0-14.0

■ **Mechanical properties of all-weld metal as per AWS**

	YP (MPa)	TS (MPa)	EI (%)
Typical	500	550	30
Example	480	530	30

■ **Recommended welding parameters**

Dia.	2.5mm	3.15mm	4.0mm
F, HF, H, VD	45~95A	60~125A	105~170A
VU, OH	45~95A	60~125A	100~150A

■ **Polarity**

Example	AC
Guaranty	AC, DC-EP, DC-EN

■ **Approval**

■ **Packages**

Dia. (mm)	Length (mm)	Kg per Pack (Kgs)	Pack per Carton (No. of Packs)	Kgs per Carton (Kgs)
2.50	350	2	6	12
3.15	350	2	6	12
4.00	350	2	6	12

