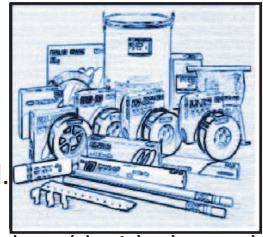


Shielded Metal Arc Welding

ANU BOND D2MoL SPL(AWS:SFA 5.4,E309L Mo- 17) AWS:SFA 5.4,E309L Mo-17

Application :

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 for ferritic chromium stainless steel specially designed for welding root run in clad steel as well mild steel.

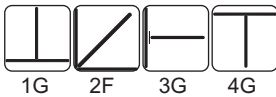
Chemical composition of All-Weld metal (%) as per AWS

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 all-weld metal as per AWS

UT.S (N/mm ²)	Elongation (L=4d) %
520 Min	30 Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	DC (+)	45-85
3.15 x 350	2	12		85-115
4.00 x 350	2	12		100-140
5.00 x 350	2	12		140-180

