

Shielded Metal Arc Welding

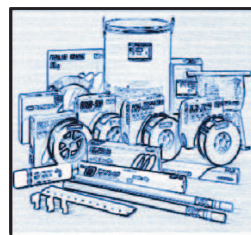
ANU BOND - D2 Mo L (E 309LMo -16)

AWS: SFA 5.4, E 309LMo - 16, IS: 5206 E309 E 23, 12.2 L R 26

Stainless Steel Welding Electrodes

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 electrodes yielding 25 Ni, 12 Cr, 2 Mo stainless steel weld deposit. The ferritic austenitic weld metal is very crack resistance smooth weld with clean edges. suitable for welding build up turbine running made of ferritic chromium stainless steel specially designed for welding root run in clad steel as well as mild steel.

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

C	Mn	Si	P	S	Cr	Ni	Mo
0.04 Max	0.50-2.50 Max	1.00 Max	0.040 Max	0.030 Max	22.0- 25.0	12.0-14.0	2.0 - 3.0

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Elongation (L=4d) %
520 Min	30 % Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	Kg / Packet	Kg. Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC/ DC (+)	45-85
3.15 x 350	2	12		85-115
4.00 x 350	2	12		100-145
5.00 x 350	2	12		135-180

