

Shielded Metal Arc Welding

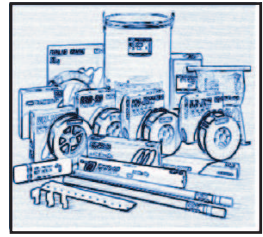
ANU BOND - D2 L (BASIC) (E 309L-15)

AWS: SFA 5.4, E 309 -15 IS:5206,E23,12 LB20

Stainless Steel Electrodes

Application :

Recommended for AISI 309 grade of stainless steel and straight chrome steel for joining clad steel, low alloy steel and carbon steel.



Characteristics on Usage :

A medium heavy coated basic type all position electrode yielding 25 Cr 12 Ni stainless steel weld deposit. This is characterized by excellent all round performances and metal properties including resistance to chemical corrosion. Temperatures upto 1100 °c Suitable for steel containing 22-26 % Cr and 11-14 % Ni and also for joints between 18 Cr. 8 Ni stainless steel and mild steel or low alloy steel.

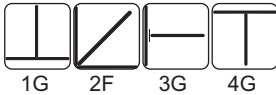
Chemical composition of All-Weld metal (%) as per AWS

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	0.75 Max

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Elongation (L=4d) %
550- 640	36- 45

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		135-180

