

Shielded Metal Arc Welding

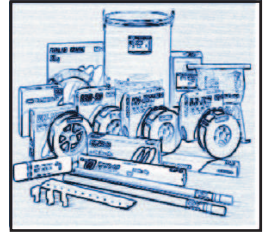
ANU BOND - D2L (E 309L -17)

AWS: SFA 5.4, E 309L - 17

Stainless Steel Welding Electrodes

Application :

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



Characteristics on Usage :

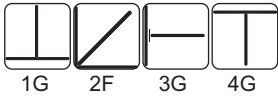
A medium heavy coated rutile type all position electrode yielding 25 Cr 12 Ni 2.50 Mo stainless steel weld deposit. This is characterized by excellent all round performance and metal properties including resistance of chemical corrosion. Temperatures up to 1100 °C.

C	Mn	Si	P	S	Cr	Ni
0.10 Max	1.0-2.50 Max	1.00 Max	0.040 Max	0.030 Max	22.0- 25.0	12.0-14.0

Mechanical properties of all-weld metal as per AWS

UTS	Elongation
(N/mm ²)	(L=4d) %
540 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		100-140
5.00 x 350	2	12		135-180

