

Shielded Metal Arc Welding

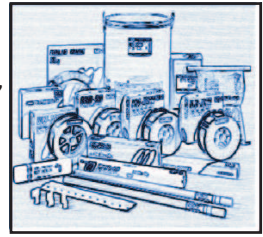
ANU BOND - D2L (E 309L -16)

AWS: SFA 5.4, E 309L - 16, IS: 5026 E23, 12 R 26

Stainless Steel Welding 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 coted rutile type all position electrode yielding 25 Cr 12 Ni 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. 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.

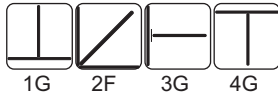
Chemical composition of All-Weld metal (%) as per AWS

| C | Mn | Si | P | S | Cr | Ni | Mo |
|-----------|---------------|----------|-----------|-----------|------------|-----------|----------|
| 0.040 Max | 0.50-2.50 Max | 1.00 Max | 0.040 Max | 0.030 Max | 22.0- 25.0 | 12.0-14.0 | 0.75 Max |

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 | 18 | | 135-180 |

