ROYAL - D2 Mo (E 309 Mo - 16)

AWS : SFA 5.4, E 309 Mo - 16
IS : 5206 E 309 E 23, 12.2 R 26

Applications

Suitable for welding steel containing 22 – 26% and 11 - 14 % Ni, 2 - 3 % Mo also for joints between 18 Cr - 8 Ni stainless steel and mild steel or low alloy steel.

Characteristics on Usage

A medium heavy coated rutile type all position electrode giving 25 Cr 12 Ni, 2 Mo stainless steel weld deposit, the addition of molybdenum improves tensile strength and resistance to chemical corrosion and heat, standing upto 1100º C temperature. It gives a stable arc, low spatter, smooth weld bead and easily detachable slag.

Notes On Usage

- 1) Dry the electrode a 350°C for 60 Min- before use.
- 2) Keep the arc as short as possible.
- 3) Use currents as low as possible to avoid excessive dilution.

Welding Positions

1G 2F 3G 4G

Chemical Composition Of Weld Metal

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

Mechanical Properties Of Weld Metal

U.T.S. (N/mm²)	ELONGATION (L = 4d) %
550	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 X 350	2	10	4.40	22.05	45 – 85	AC / DC (+)
3.20 X 350	2	10	4.40	22.05	85 - 115	
4.00 X 350	2	10	4.40	22.05	100 - 145	
5.00 X 350	2	10	4.40	22.05	135 – 180	

Packing

Vaccum pack