

**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**

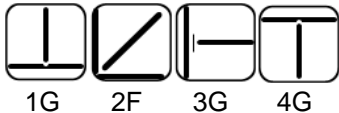
Suitable for welding steel containing 22 – 26% and 11 - 14 % Ni, 2 - 3 % Mo also for joints between 18 Cr - 8 Ni stainless steel and mild steel or low alloy steel.

**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 1100° C temperature. It gives a stable arc, low spatter, smooth weld bead and easily detachable slag.

**Notes On Usage**

- 1) Dry the electrode at 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****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/mm <sup>2</sup> )	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