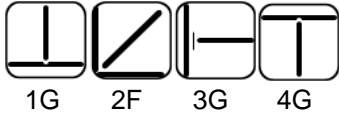


**Applications**

Dissimilar joint welds of and between high strength mild steel & low alloy quenched & tempered steel stainless steel. Ferrite Cr. & Austenitic – Cr/Ni steel. Cladding for first layer of corrosion resistant weld cladding on ferrite steels.

**Characteristics on Usage**

Royalfil GS-D2MO is a stainless steel flux core welding wire for all position welding with co2 shielding gas. It gives the 23% Cr and 12% Ni & 2% Mo weld deposit. It is suitable for the welding of similar composition of steel.

**Welding Positions****Recommended Stick Out**

15-20mm

**Shielding Gas**

Carbon Dioxide (CO<sub>2</sub>) shielding  
Gas Flow :15-20 Lit / Min

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cu %
Typical Values	0.030	1.60	0.65	0.010	0.020	23.20	12.75	2.50	0.10
Spec. Reqd.	0.04 Max	0.5-2.50	1.0 Max	0.030 Max	0.040 Max	21.0-25.0	12.0-16.0	2.0-3.0	0.75 Max

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
Typical Values	620	32
Spec. Reqd.	520 Min	25 Min

**Welding Parameters (DC + VE)**

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	160-210	26-30	120-210	22-26	160-210	26-30
1.60	190-250	26-30	160-250	21-27	190-250	26-30

**Packing**

12.5 kgs. vaccum packed plastic spool.