ROYAL - D2 (E 309 - 16)

AWS : SFA 5.4, E 309 - 16
IS : 5206 E 23, 12 R 26

Applications

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 coated 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 to chemical corrosion. temperatures upto 1100? cent. 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.

Notes On Usage

- 1) Dry the electrode a 350°C for 60 Min- before use .
- 2) Keep the arc as short as possible.

Welding Positions

1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %
0.15 Max	0.50 - 2.50	1.00 Max	0.030 Max	0.040 Max	22.0 - 25.0	12.0 - 14.0

Mechanical Properties Of Weld Metal

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

Approvals

E.I.L., P.D.I.L., TOYO [TEIL].

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / DC (+)	45 – 85
3.15 x 350	2	10		85 - 115
4.00 x 350	2	10		100 - 140
5.00 x 350	2	10		135 - 180

Packing

Vaccum packing