# ROYAL - D2L (E 309L - 16)

AWS : SFA 5.4, E 309L - 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 % | Mo % |
|---|---|---|---|---|---|---|---|
| 0.040 Max | 0.50 - 2.50 | 1.00 Max | 0.030 Max | 0.040 Max | 22.0 - 25.0 | 12.0 - 14.0 | 0.75 Max |

## Mechanical Properties Of Weld Metal

| U.T.S. (N/mm²) | ELONGATION ( L = 4d ) % |
|---|---|
| 540 | 30 % Min |

## Approvals

IOCL

## 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