

# ROYAL D2L MOD (AWS:SFA 5.4 E 309L-17)

AWS:SFA 5A, E309L -17 EN ISO 3581 A E 22 12 LR 12

## 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°C. 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.

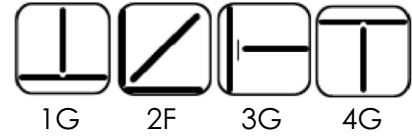
## Approvals

B.V.

## Packing

Vaccum packing

## Welding Positions



## Notes On Usage

- ⚠ Dry the electrode at 350°C for 60 Min- before use.
- ⚠ Keep the arc as short as possible.

STAINLESS STEEL ELECTRODES

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
540	30 % Min

## 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