ROYALFIL GS D2MOL (E309LMoT1-1)

AWS A / SFA 5.22 E309LMoT1-1
EN ISO 17633 A T23122LRC1

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

1G 2F 3G 4G

Recommended Stick Out

15-20mm

Shielding Gas

Carbon Dioxide (CO_2) 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^2)	ELONGATION (L = 4d) %
Typical Values	620	32
Spec. Reqd.	520 Min	25 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (A)	Vertical - Up (V)	Overhead (A)	Overhead (V)
1.20	160-210	26-30	120-160	22-26	150-180	26-30
1.60	190-250	26-30	160-200	22-27	180-210	26-30

Packing

15 kgs. vaccum packed plastic spool.