

ROYALFIL GS D2MOL (E309LMoT1-1)

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

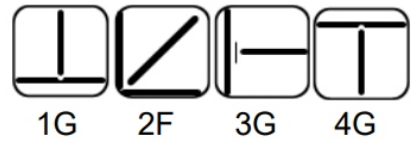
Applications

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



Recommended Stick Out

15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) Shielding
Gas Flow : 15-20 Lit / Min

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%
0.04 Max	0.5-2.50	1.0 Max	0.03 Max	0.04 Max	21.0-25.0
NI%	Mo%	Cu%			
12.0-14.0	2.0-3.0	0.75 Max			

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION. (L = 4d) %
520-620 Min	25-32 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (V)	Vertical - Up (V)	Overhead (V)	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. Vacuum packed plastic spool