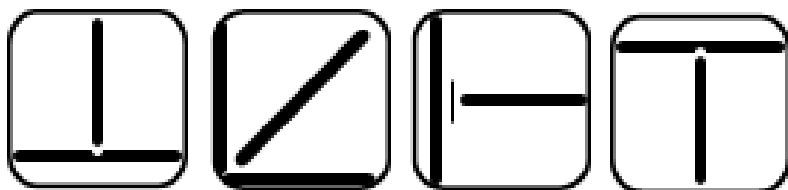


**ROYALFILGS D2H (E309HT1-1)**AWS A / SFA 5.22  
E309HT1-1**Applications**

Royalfil-GS-D2H is suitable for the welding of dissimilar metals such as stainless steel and carbon steel or stainless steel and low alloy steel. Ferrite content is about 6 -7 FN which makes this welding wire suitable for welding of 23 Cr – 12.5 Ni wrought & cast steels designed for corrosion and oxidation resistance.

**Characteristics on Usage**

Royalfil GS-D2H is a stainless steel flux core welding wire for all position welding with co2 shielding gases. It gives the 23% Cr and 12% Ni weld deposit with excellent all around performance and resistance to chemical corrosion. Carbon restriction helps to provide higher tensile strength & creep strength at elevated temp.

**Welding Positions**

1G

2F

3G

4G

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %
Typical Values	0.055	1.60	0.65	0.010	0.030	23.20	12.50
Spec. Reqd.	0.04-0.10	0.5-2.50	1.00 Max	0.03 Max	0.040 Max	22.0-25.0	12.0-13.0

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
Typical Values	610	35
Spec. Reqd.	550 Min	30 Min

**Welding Parameters (DC + VE)**

Diameter (mm)	Flat & Horizontal	Flat & Horizontal	Vertical - Up	Vertical - Up	Overhead	Overhead
	(A)	(V)	(A)	(V)	(A)	(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**

12.5 kgs. vacuum packed plastic spool.