

ROYAL 1126

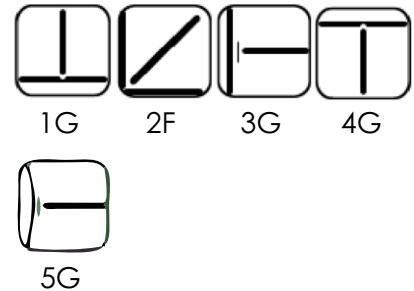
Applications

Welding of Austenitic stainless Steel., heat resistant Cr-Ni steels of the type 25 Cr / 20 Ni (NCT ,AISI 310 ,Ugine NS 30, Avesta 254E ,Sandvik 15 RE 10). Also welding of steel with high carbon content often used in building field . Furnace linings, furnace parts, burners, heat treatment pots and baskets.

Notes on Usage

- ☞ Clean and degrease the area to be welded.
- ☞ For heavy thickness prepare a 60° included angle Vee. possible arc length.
- ☞ Fit up should be accurate for long joints. Then weld at regular intervals and use jigs and fixtures to avoid distortion.
- ☞ Use DCRP (DC+) on DC Power source for good ripple and finish. Stringer bead technique with shortest possible arc length is recommended. possible arc length.

Welding Positions



Characteristics on Usage

Fully austenitic ,heat resistant deposit heat resistant at working temperature up to 1200°C in oxidizing ,sulphur free atmosphere.

LOW HEAT INPUT ELECTRODE

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550 - 650	30 - 35

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	18	60 - 80
3.15 X 350	2	18	90- 110
4.00 X 350	2	18	120 - 140