

ROYAL 1128

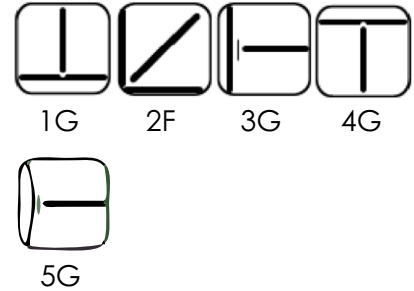
Applications

Welding OF Austenitic stainless Steel Joining of Stainless Steel to lower alloy steels, carbon steel , Mild Steel. It is also used for welding of clad side of 18/8 clad steel.

Notes on Usage

- ☞ Clean and degrease the area to be welded. For heavy thickness prepare a 60° included angle Vee.
- ☞ 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.

Welding Positions



Characteristics on Usage

It is all position welding electrode giving 25% Cr, & 12% Ni weld deposit . It is excellent resistance to chemical corrosion and heat with very good weld bead finish.

LOW HEAT INPUT ELECTRODE

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550 Min	30- 40

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	18	50 - 75
3.15 X 350	2	18	90 - 110
4.00 X 350	2	18	100 - 130