

ROYAL – 320 (E 320LR -16)

AWS : SFA 5.4, E 320LR - 16

Applications

Suitable for welding of HV -9A stainless steel , alloy for high temp. service. For fabricating carpenter 20 stainless steel For application where resistance to severe corrosion is required For a wide range of chemical including sulphuric acid and sulphurous acids and their salts. For repair of casting having similar chemical composition.

Characteristics on Usage

A medium heavy rutile coated all position electrode giving a smooth arc, medium penetration and least spatter. The slag peels off easily leaving a smooth bead having fine ripples. The weld deposit can withstand temp upto 1200 °C in continuous service. Excellent resistance to chemical corrosion and heat. The electrode is to be kept dry at 300 C for 1 hour before welding.

Notes On Usage

- ☞ Dry the electrode a 250-300°C for 60 Min- before use.
- ☞ Keep the arc as short as possible.

Welding Positions



Packing

Vaccum Pack

STAINLESS STEEL ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%	Cu %	Nb%
0.03 Max	1.5 – 2.50	0.30 Max	0.015 Max	0.020 Max	19.0 – 21.0	32.0 – 36.0	2.0 – 3.0	3.0 – 4.0	0.40 Max

Mechanical Properties Of Weld Metal

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

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / DC (+)	50 – 75
3.15 x 350	2	10		80 – 120
4.00 x 350	2	10		120 – 160
5.00 x 350	2	10		160 – 200