

ROYAL 1103

Applications

It is specially used for welding of sheet metal works. It can be used for welding of mild of higher thickness, autobodies, Storage tanks, wagons, ships, boilers, vehicle chassis etc.

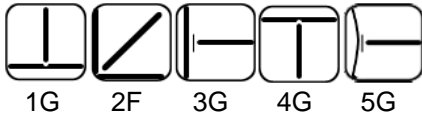
Characteristics on Usage

Smooth and stable arc to ensure good bead finish, easy peeling slag, least spatter, weld bead of X- ray quality with appropriate penetration..

Notes On Usage

► Clean the weld area form crack, pores and any deposits, use low current ensure short arc and stringer bead technique.

Welding Positions



Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
470 - 560	20 - 28

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	60 - 90
3.15 X 350	2	10	90 - 140
4.00 X 350	2	10	120 - 160
5.00 X 350	2	10	180 - 230