

# ROYAL 1117

## Applications

Welding and surfacing of Cast iron, joining of Cast Iron to steel. Economical electrode particularly indicated for massive parts and large casting .e.g. repair of foundry defects, damaged or cracked casting. Can be successfully used on rusty, corroded and oil soaked parts. For obtaining better machinability deposit final pass with RL -1115 or RL -1119.

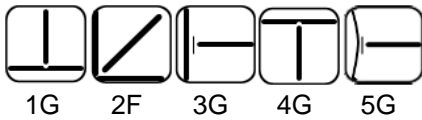
## Characteristics on Usage

Electrode with good bonding properties even on difficult to weld cast iron. Close colour match between deposit and base material. Non machinable slope by grinding.

## Notes On Usage

- Clean the welding zone, select the lowest amperage possible .use short arc
- guide the electrode steeply since electrode gives a spray transfer, helpful for sealing pores in cast iron.
- After each bead peen the deposit. If the surface of welded joint must be machinable, weld the cover passes with either RL- 1115 OR RL -1119 tresses.

## Welding Positions



## Mechanical Properties Of Weld Metal

U.T.S.  
(N/mm<sup>2</sup>)  
600 Max

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	40-70
3.15 X 350	2	10	60-120
4.00 X 350	2	10	80-150