

ROYAL 1119

Applications

Hot and cold Welding of Cast iron part of Grey Cast Iron , nodular graphite iron , malleable iron subject to heavy wear. Joining of Cast material with steel. The electrode is most suitable for the surfacing of the above materials. Casting machinable parts , bearing blocks, frames, foundry casting etc.

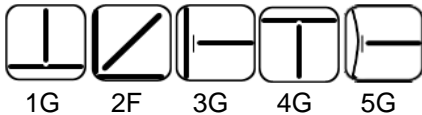
Characteristics on Usage

Electrode with Excellent welding characteristics The deposit is machinable and crackproof. Good bonding on difficult to weld Cast iron.

Notes On Usage

- Sufficient amount of the casting skin should be removed.
- Depending on the job thickness a U weld or double U weld or should be made, use shortest possible arc length.
- The pass width should not be more than twice the diameter of the core wire.
- Deslag every weld bead and peen the weld metal carefully
- Restrike the arc on the weld metal and never on the parent metal.

Welding Positions



1G 2F 3G 4G 5G

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	HARDNESS ON III rd LAYER
35 - 45	150 - 190 BHN

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	40 - 90
3.15 X 350	2	10	50 - 90
4.00 X 350	2	10	70 - 100
5.00 X 350	2	10	100 - 180