

ROYAL 1104

Applications

ideally suited for joining and building up for low and medium carbon steels. Equally good for depositing buffer layers before hard facing pressure vessels ,steel casting , vehicle chassis etc.

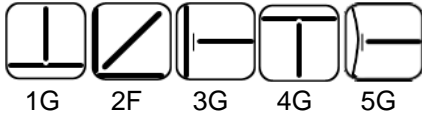
Characteristics on Usage

The weld bead has good appearance and slag peels off by itself The weld metal is extremely ductile and resistant to cracking

Notes On Usage

- To, get best results dry the electrodes at 250 oC for about 2 hours before use.
- Cleaning the weld area is must to achieve good results.

Welding Positions



Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
600 Min	22 - 30

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	18	60 - 90
3.15 X 350	2	18	90 - 140
4.00 X 350	2	18	120 - 160
5.00 X 350	2	18	180 - 250