

ROYAL 1126

Applications

Welding of Austenitic stainless Steel., heat resistant Cr-Ni steels of the type 25 Cr / 20 Ni (NCT ,AISI 310 ,Ugine NS 30, Avesta 254E ,Sandvik 15 RE 10). Also welding of steel with high carbon content often used in building field . Furnace linings, furnace parts, burners, heat treatment pots and baskets.

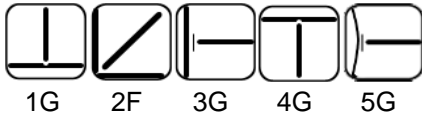
Characteristics on Usage

Fully austenitic ,heat resistant deposit heat resistant at working temperature up 1200°C in oxidizing ,sulphur free atmosphere.

Notes On Usage

- Clean and degrease the area to be welded.
- For heavy thickness prepare a 60° included angle Vee.
- Fit up should be accurate for long joints. Then weld at regular intervals and use jigs and fixtures to avoid distortion.
- Use DCRP (DC+) on DC Power source for good ripple and finish. Stringer bead technique with shortest possible arc length is recommended.

Welding Positions



Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550 - 650	30 - 35

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	18	60 - 80
3.15 X 350	2	18	90- 110
4.00 X 350	2	18	120 - 140