

ROYAL 1128

Applications

Welding OF Austenitic stainless Steel Joining of Stainless Steel to lower alloy steels, carbon steel , Mild Steel. It is also used for welding of clad side of 18/8 clad steel.

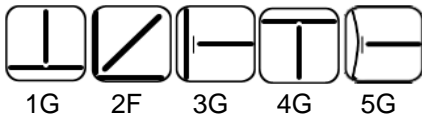
Characteristics on Usage

It is all position welding electrode giving 25% Cr, & 12% Ni weld deposit . It is excellent resistance to chemical corrosion and heat with very good weld bead finish..

Notes On Usage

- Clean and degrease the area to be welded. For heavy thickness prepare a 60 o 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 Min | 30- 40 |

Packing and Welding Current

| SIZE (mm) | KG PER PACKET | KG PER CARTON | In Amps |
|-------------|---------------|---------------|-----------|
| 2.50 X 350 | 2 | 18 | 50 - 75 |
| 3.15 X 350 | 2 | 18 | 90 - 110 |
| 4.00 X 350 | 2 | 18 | 100 - 130 |