

# 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 <sup>2</sup> )	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	10	60 - 90
3.15 X 350	2	10	90 - 140
4.00 X 350	2	10	120 - 160
5.00 X 350	2	10	180 - 250