

# ROYAL 1125

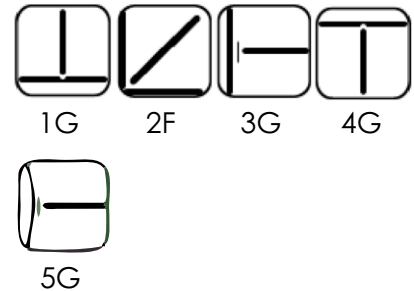
## Applications

Welding of austenitic stainless Cr-Ni-Mo steels of the type 18 Cr/ 8 Ni + Mo (V4A, AISI 316, uginé NSM 22, Avesta 832SK, soderfors564, sandvik OR60, UHB stainless 24 etc.) for repair of cracks in heavy machinery parts and earth moving equipments. Hot forging dies, dyeing and daily equipment etc. Chemical vessels and plant breweries and food equipment.

## 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.
- ☞ Stringent bead technique with shortest possible arc length is recommended.

## Welding Positions



## Characteristics on Usage

The deposit containing extremely little carbon, is highly resistant against strong chemical influence and inter crystalline corrosion. Resistant against grain disintegration upto 300°C.

LOW HEAT INPUT ELECTRODE

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
500 - 650	30 - 40

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / DC (+)	40 - 70
3.15 x 350	2	10		55 - 100
4.00 x 350	2	10		80 - 135