

ROYAL 1B (BASIC) (AWS:SFA 5.4, E 347 -15)

AWS : SFA 5.4, E 347-15 EN ISO 3581 A E 19 9 Nb B22

Applications

AISI steels 321 and 347 generally on 18/8 steels stabilized by Titanium or Niobium in the manufacture of equipment for chemical, food & aircraft industries, also used for welding unstabilized stainless steels of AISI 301, 302, 304 & 308 types.

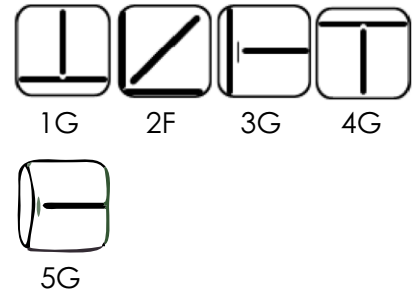
Characteristics on Usage

It is a rutile coated stainless steel electrode which deposits high carbon i.e. 0.04 to 0.080, 19Cr, and 10 Ni type of weld metal which gives high tensile and creep strength at elevated temperature. This electrode are used for welding AISI 304H type of base material. It is running with smooth arc with excellent weld bead finish and self lifting slag.

Notes On Usage

- ☞ Dry the electrode at 350°C for 60 Min- before use .
- ☞ Keep the arc as short as possible.
- ☞ Remove rust,water,oiland paint from the surface to be welded.

Welding Positions



Packing

Vaccum Pack

STAINLESS STEEL ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Nb (Cb) %
0.04 - 0.08	0.50 – 2.50	1.0 Max	0.030 Max	0.040 Max	18.0-21.0	9.0-11.0	0.50-0.90

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
520	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	DC (+)	45 – 85
3.15 x 350	2	10		85-120
4.00 x 350	2	10		100-140
5.00 x 350	2	10		140-180