

ROYAL – 1C (E 308L – 16)

AWS : SFA 5.4, E 308L - 16 IS : E 19-9 LR - 16 EN ISO 3581 A E 19 9 LR 12

Applications

Ideally suited for welding of stainless steel of AISI grade 301, 302, 304, 304L, 308, 308L composition. For welding of household articles, milk and soap industries Hospital apparatus, nuclear plant.

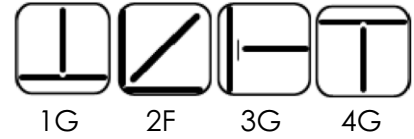
Characteristics on Usage

An extra low carbon lime titania all position 19 Cr - 10 Ni stainless steel electrode which is highly resistance. intergranular corrosion, cracking, oxidation and scaling very smooth running with extremely smooth removal of slag leaving a uniform and fine rippled bead characterized by excellent all round performance and weld metal properties upto 250° C.

Notes On Usage

- It is mostly effective to protect with welding, keeping the arc as short as possible in flat position .
- Remove dirt such as oil and dust from groove.
- Dry the electrode at 350°C for 60 Min- before use .

Welding Positions



Approvals

N.P.C.I.L. , IOCL, KNPC, TPL

Packing

Vaccum Pack

STAINLESS STEEL ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%	Ni%
0.040 Max	0.50 - 2.0	0.75 Max	0.030 Max	0.040 Max	18.00 - 21.0	9.0 - 11.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
520	35 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / DC (+)	45 – 85
3.15 x 350	2	10		85 - 115
4.00 x 350	2	10		100 – 140
5.00 x 350	2	10		140 – 180