

ROYAL 2C (BASIC) (AWS:SFA 5.4, E 316L -15)

AWS : SFA 5.4, E 316 L - 15 EN ISO 3581 A E 19 12 3 LB 22

Applications

Suitable of welding AISI 316L & 317L type of stainless steel Applications in chemical plants, paint, pulp paper and textile industries.

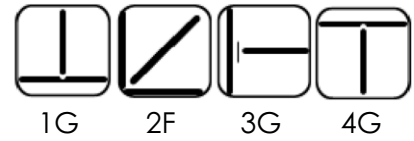
Characteristics on Usage

An extra low carbon basic coated all position 18Cr, 12 Ni, 2 Mo stainless steel electrode for welding AISI 316-L equivalent grades of stabilized steel and non stabilized chromium nickel steel which are resistant to atmospheric corrosion of the 316 type. It is 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.

Notes On Usage

- ⌚ Weaving width should be within two and half times of electrodes diameter.
- ⌚ Remove dirt such as oil and dust from groove.
- ⌚ Dry the electrode at 350°C for 60 Min. before use.

Welding Positions



Packing

Vaccum packing

STAINLESS STEEL ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%
0.040 Max	0.50-2.50	1.0 Max	0.030 Max	0.040 Max	17.0-20.0	11.0-14.0	2.0 - 3.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
490 Min	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 - 115
4.00 x 350	2	10		100 – 140
5.00 x 350	2	10		140 – 180