

ROYAL 385ZF (E 385 - 16)

AWS: SFA 5.4, E 385 - 16 EN ISO 3581 A E 20 25 5 CuN LR 12

Applications

These electrodes are used primarily for welding of type 904 L material for the handling of sulphuric acid and many chloride contain media. It is also used for HV - 9 A and HV-9 stainless steel and similar alloy for high temperature services in the jet aircraft industry

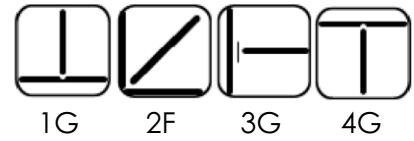
Characteristics on Usage

It is semi basic coated all position electrode giving a smooth arc, medium penetration & weld deposit of 20 % Cr, 25% Ni, 5 % Mo & 1.5 % Cu. Which possesses excellent corrosion and heat resistance up to 1200o C. Frequently encountered in fully austenitic weld metal leaving smooth bead having fine ripples with self lifting slag.

Packing

Vaccum Pack

Welding Positions



Notes On Usage

- ⌚ Dry the electrodes at 350° C for 60 min. before use.
- ⌚ Keep the current as low as possible.
- ⌚ Remove rust, water, oil, paint etc. from groove.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%	Cu %
0.03 Max	1.0 - 2.5	0.90 Max	0.020 Max	0.030 Max	19.5 - 21.5	24.0 - 26.0	4.20 -5.20	1.2 - 2.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550	30

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 x 350	2	10	4.40	22.05	50 - 70	AC / DC (+)
3.20 x 350	2	10	4.40	22.05	80-100	
4.00 x 350	2	10	4.40	22.05	100-140	
5.00 x 350	2	10	4.40	22.05	140-180	