

ROYAL 5511

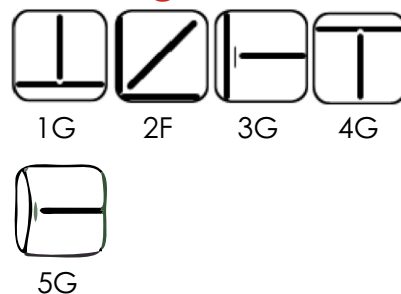
Applications

Welding of monel and monel plated steels, joining of monel to steel, overlays of corrosion resistant monel on steel. Repairing defects in monel castings, used in fabrication, chemical food, dairy and pharmaceutical industries. Before surfacing stainless steel with Royal 5511 use Royal 5521 as buffer layer.

Characteristics on Usage

Use a short arc do not weave the arc too wide. The base plate should be free from oil, grease and scale. Preheat the job between 100-150°C depending on thickness

Welding Positions



LOW HEAT INPUT ELECTRODE

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
480-550 Min	30 - 35 %

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	60 – 80
3.15 X 350	2	10	75 - 100
4.00 X 350	2	10	100 – 140
5.00 X 350	2	10	140 – 180