

ROYAL (Ni) CHROME (E 10016 G)

AWS : SFA 5.5, E 10016 G

IS : E 68BG126

Applications

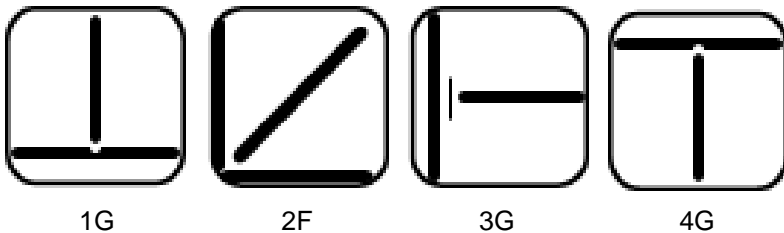
It is used for welding earth moving equipment's. Steam turbine, rotors of chemical plants. Heavy machinery parts made of high tensile steel. Automotive parts and armour steel of Ni-Cr-Mo based.

Characteristics on Usage

It is a hydrogen controlled medium heavy coated all position electrode. It has better creep resistance properties as well as corrosion resistance properties. It gives weld deposit which contain 1% of Cr & 2.5% of Ni. The weld metal is of radiographic quality and possess excellent strength combined with good toughness. This electrode is used for welding of high tensile, low alloy steels, which contains Ni-Cr-Mo types. Therefore, it is used in Chemical plants, especially for the welding of steam turbine, rotors etc. Redry the electrodes at 300 °C about an hour for better results

Notes On Usage

- ✍ 1) Dry the electrode at 350-400 °C for 60 Min- before use.
- ✍ 2) Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose.
- ✍ 3) Preheat at 100 - 150 °C The temp. varies in accordance with plate thickness and kind of steel.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.10 Max	1.00 Min	0.20 – 0.50	0.030 Max	0.030 Max	0.8 – 1.20	2.20 – 2.80	0.60–

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT R. Temp.(27 ± 2)
690 Min	600 Min	16 % Min	50 Joules Min

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	60 – 90
3.15 x 450	100	400		100– 130
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 – 230