

# ROYAL 1115 ( )

## Applications

A unique electrode for cold welding of cast iron without preheat and for joining cast iron to mild steel. Also suitable for surfacing cast iron parts subject to erosion, corrosion and high temperatures. Best suited for repairing intricate cast iron parts, water pumps housing, Electric motor bodies and covers, Machine frames, Cylinder blocks, gears, also ideal for salvaging foundry castings, Gears box and differential housings, lathe beds,

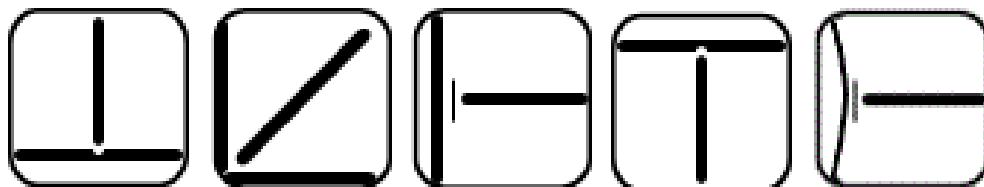
## Characteristics on Usage

Smooth and stable arc, suitable for positional welding very little mixing up with base material, consequently the heat affected zone is easily machinable. No undercut.

## Notes On Usage

- ✍ Clean the welding zone and check the surface for cracks and defects, use a short arc with low current to deposit a string bead not exceeding 50 mm
- ✍ Peen the deposit to reduce residual stresses.

## Welding Positions



1G

2F

3G

4G

5G

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	HARDNESS ON III rd LAYER
300-340	130-150 Brinell

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	40-70
3.15 X 350	2	10	60-110
4.00 X 350	2	10	80-120
5.00 X 350	2	10	