

# ROYAL 1124 ( )

## Applications

For joining 18/8 stainless steel eg V2A, AISI 304/308, En 508A, uquine NS 22, Avesta 832 NV, soderfors553, sandvik OR2, UHB stainless 3, staybright FSL, silver fox 304 etc. Which are used in chemical plants, dye works, breweries food industry and hospital equipments.

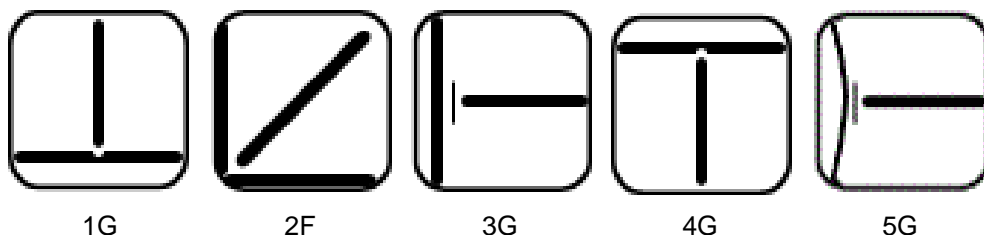
## Characteristics on Usage

Corrosion and scale resistant deposit with extremely low carbon content ( C< 0.04 %) easy arc striking. Flat shining bead , free from inter crystalline corrosion.

## Notes On Usage

- ✂ Clean and degrease the area to be welded. For heavy thickness prepare a 60° included angle Vee. Fit up should be accurate for long joints.
- ✂ Then weld at regular intervals and use jigs and fixtures to avoid distortion. Use DCRP (DC+) on DC Power source for good ripple and finish.
- ✂ Stringent bead technique with shortest possible arc length is recommended.

## Welding Positions



## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
530 - 650	35 - 40

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC/DC (+)	60 - 80
3.15 x 350	2	10		80 - 120
4.00 x 350	2	10		120 - 160