

# ROYAL 1128 ( )

## Applications

Welding OF Austenitic stainless Steel Joining of Stainless Steel to lower alloy steels, carbon steel , Mild Steel. It is also used for welding of clad side of 18/8 clad steel.

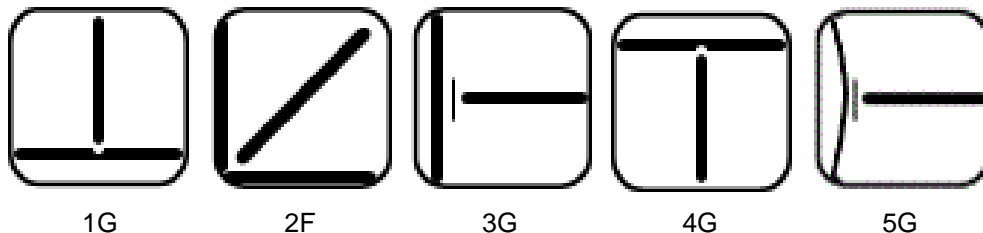
## Characteristics on Usage

It is all position welding electrode giving 25% Cr, & 12% Ni weld deposit . It is excellent resistance to chemical corrosion and heat with very good weld bead finish..

## Notes On Usage

- ✍ Clean and degrease the area to be welded. For heavy thickness prepare a 60 o 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. Stringer 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 ) %
550 Min	30- 40

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	18	50 - 75
3.15 X 350	2	18	90 - 110
4.00 X 350	2	18	100 - 130