

ROYAL 1B (BASIC) (AWS:SFA 5.4, E 347 - 15)

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Applications

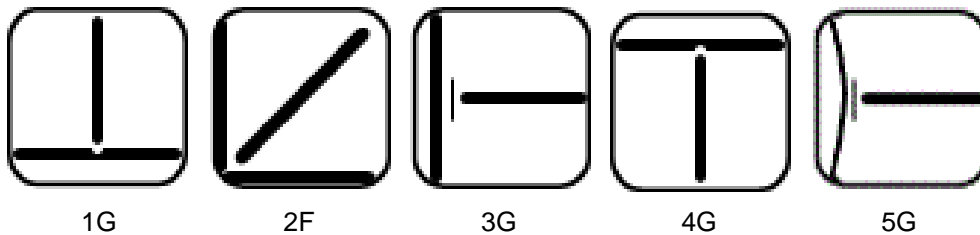
AISI steels 321 and 347 generally on 18/8 steels stabilized by Titanium or Niobium in the manufacture of equipment for chemical, food & aircraft industries, also used for welding unstabilized stainless steels of AISI 301, 302, 304 & 308 types.

Characteristics on Usage

A medium heavy coated basic type all position electrode which is almost spatter free, has a smooth arc, with excellent weld bead finish and self lifting slag. A niobium stabilised stainless steel of 19 Cr - 10 Ni type weld metal has excellent creep strength and is of radiographic quality. Welding can be done on DC(+) polarity, high degree of corrosion resistance in oxidising environment such as nitric acid.

Notes On Usage

- 1) Dry the electrode at 350°C for 60 Min- before use .
- 2) Keep the arc as short as possible.
- 3) Remove rust,water,oiland paint from the surface to be welded.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Nb (%)
0.08 Max	0.50-2.50	1.0 Max	0.030 Max	0.040 Max	18.0-21.0	9.0-11.0	0.50-

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
520 Min	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	DC (+)	45-85
3.15 x 350	2	10		85-120
4.00 x 350	2	10		100-140
5.00 x 350	2	10		140-180

Packing

Vaccum packing