

**ROYAL - 2B (E 318 - 16)**

AWS : SFA 5.4, E 318 - 16

IS : E 19-12 - 2 Nb – R26

**Applications**

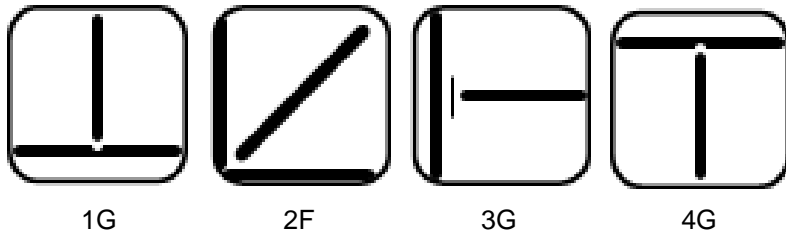
For the fabrication of chemical plants. Paper mill equipments Pickling plant etc., Joining and surfacing of similar composition of stainless steel.

**Characteristics on Usage**

It is a stainless steel electrode it produces a columbium stabilized 19/12/Mo weld metal. It is a all position electrode having good resistant to corrosion and improved creep strength. It is ideally suited for joining for stainless steel of similar composition the weld metal has excellent creep strength upto 850 °C and is of radiographic quality, recommended for welding AISI 316, 317 & 318 type of stainless steel.

**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 %	Mo
0.080 Max	0.50 - 2.50	1.00 Max	0.030%	0.040%	17.0 - 20.0	11.0 - 14.0	2.0 -

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
550 Min	25% Min

**Approvals****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 - 100
4.00 x 350	2	10		110 - 140
5.00 x 350	2	10		140 – 180

**Packing**

Vaccum packing