

**ROYAL - CW (E 310 - 16)**

AWS : SFA 5.4, E 310 - 16

IS : E25-20 R 26 X

**Applications**

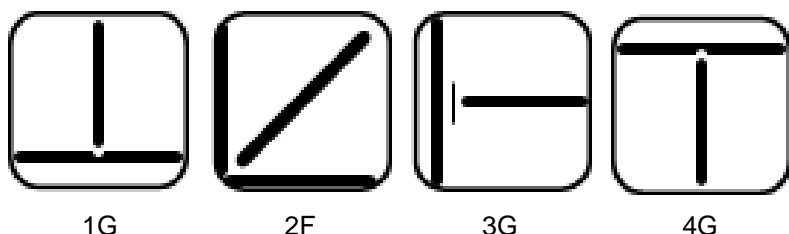
Suitable for welding of AISI 310 type of stainless steel plates. German steel, Clad steel, straight chrome steel and dissimilar steel. Gas turbine combustion chamber parts, High temperature furnace parts, Annealing boxes etc.

**Characteristics on Usage**

A medium heavy coated rutile type all position stainless steel electrode with excellent welding characteristics. This unique electrode is manufactured by using 25 Cr, 20 Ni, type of core wire to give 25/20 weld deposit. The weld metal has excellent resistance to oxidation scaling up to 1200 °C in continuous service. The weld metal is fully austenitic and is of radiographic quality.

**Notes On Usage**

- ✍ 1) Dry the electrode a 350°C for 60 Min- before use.
- ✍ 2) Keep the arc as short as possible.

**Welding Positions****Chemical Composition Of Weld Metal**

| C%          | Mn%        | Si%      | S%        | P%        | Cr %        | Ni %         |
|-------------|------------|----------|-----------|-----------|-------------|--------------|
| 0.08 – 0.20 | 1.0 - 2.50 | 0.75 Max | 0.030 Max | 0.030 Max | 25.0 – 28.0 | 20.0 – 22.50 |

**Mechanical Properties Of Weld Metal**

| U.T.S.<br>(N/mm <sup>2</sup> ) | ELONGATION<br>( L = 4d ) % |
|--------------------------------|----------------------------|
| 550 Min                        | 30 % Min                   |

**Approvals**

IOCL

**Packing and Welding Current**

| SIZE ( mm ) | KG PER PACKET | KG PER CARTON | Current (Amps) | In Amps   |
|-------------|---------------|---------------|----------------|-----------|
| 2.50 x 350  | 2             | 10            | AC / DC (+)    | 50 – 75   |
| 3.15 x 350  | 2             | 10            |                | 80 – 120  |
| 4.00 x 350  | 2             | 10            |                | 110 – 140 |
| 5.00 x 350  | 2             | 10            |                | 150 – 180 |

**Packing**

Vaccum packing