

ROYAL THERM - 120G

(Low Alloy Mild Steel Electrode)

TECHNICAL DATA

- **DESCRIPTION :-** A basic coated low hydrogen iron powder type electrode used for welding high strength steel. the electrode is operating in all position and has excellent welding characteristics. the weld metal is of radiographic quality and possesses high strength combined with excellent toughness at sub Zero temperature. it is used for welding high tensile fine grained steel
- **CLASSIFICATION :-** SFA 5.5 AWS E 12018G
- **APPLICATIONS :-** Welding of Penstocks
Earth moving equipment's
Heavy duty structure made from high tensile steel.
Petrochemicals Tanks & Vessels.

CURRENT (Amps)	SIZE (mm)	CURRENT (Amps)
AC/DC (+)	2.50 x 350	60 - 90
	3.15 x 450	100 - 140
	4.00 x 450	140 - 180
	5.00 x 450	180 - 230
	6.30 x 450	230 - 280

● WELD METAL ANALYSIS :-

C %	Mn %	Si %	S %	P %
0.10Max	1.30 - 2.25	0.60Max	0.030Max	0.030Max
Cr%	Mo%	Ni%	V %	
0.30 - 1.50	0.30 - 0.55	1.75 - 2.50	0.050 Max	

● TYPICAL MECHANICAL PROPERTIES :-

Y.S.	745 - 830 N/mm ²
U.T.S.	830 N /mm ² Min
ELONGATION (L = 4d)	18 % Min
IMPACT (CVN) AT -50° C	27 Joules Min

● PACKING SPECIFICATION :- (VACCUM PACK)

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON
2.50 x 350	150	600
3.20 x 450	100	400
4.00 x 450	70	280
5.00 x 450	45	180
6.30 x 450	30	120

Manufactured in India By :
ROYAL ARC ELECTRODES LIMITED.
ISO : 9001 - 2008 Certified Company