

ROYAL 2214 AC / DC

(TIN-BRONZE ELECTRODE)

- **ALLOY BASIS :-** Cu, Sn, P
- **TECHNICAL DATA :-** UTS of Joint: 240-280 N/mm²
Elongation : 20 %
Hardness of Pure Deposit : 70 - 85 Brinell
- **APPLICATION :-** Welding and surfacing of Copper, Brass and Bronze. Joining copper and Bronze to cast iron overlays and steel. Filling cavities in copper alloy castings. Overlays on pumps , shafts and bearing surfaces. Building up missing sections.
- **PROPERTISE :-** The weld metal is free from porosity and cracks. The bead is smooth and uniform excellent colour match on bronze.
- **WELDING CURRENT: AC / DC(+):-**

SIZE (MM)	3.15	4.00
Current Range (Amps)	80 - 110	110 - 140

- **PACKING SPECIFICATIONS :-**

SIZE (mm)	KG PER PACKET	KG PER BOX
3.15 X 350	2 Kg	10 Kg
4.00 X 350	2 Kg	10 Kg

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