

# ROYAL 1106 ( )

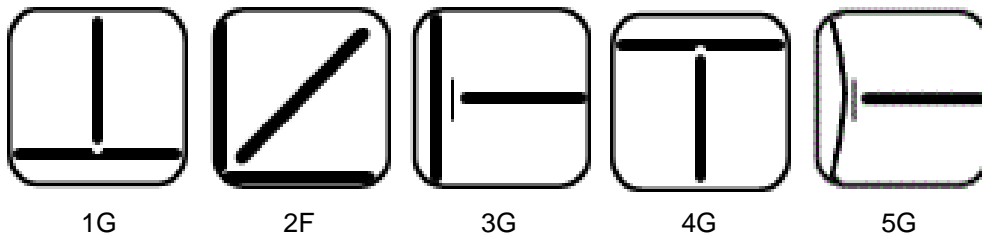
## Applications

Suitable for welding of Heavy machinery parts, earth moving equipments, automobile spring, trunnions of cement mill and other allied components, parts subject to corrosion and impact Joining and surfacing of High Carbon, low and high alloy steel, tool steel, spring steel, manganese steel, case hardening steel, high speed steel, cast steel and for difficult to weld steel and unidentified steel ,for joining dissimilar steels etc.

## Characteristics on Usage

A medium heavy coated rutile type all position electrode giving 30 % Cr. And 10 % Nickel weld deposit. The electrode has very soft arc and gives smooth and defect free austeno ferrite weld metal. Almost no distortion and embrittlement of the base material. The weld metal is resistant to friction, heat and corrosion is work hardening and shockproof gives radiography weld deposit.

## Welding Positions



## Chemical Composition Of Weld Metal

| C%       | Mn%         | Si%      | S%        | P%        | Cr %        | Ni %        | Mo   |
|----------|-------------|----------|-----------|-----------|-------------|-------------|------|
| 0.15 Max | 0.50 – 2.50 | 1.00 Max | 0.030 Max | 0.040 Max | 28.0 - 32.0 | 8.0 – 10.50 | 0.75 |

## Mechanical Properties Of Weld Metal

| U.T.S.<br>(N/mm <sup>2</sup> ) | ELONGATION<br>( L = 4d ) % |
|--------------------------------|----------------------------|
| 680 – 800                      | 19 - 25                    |

## Packing and Welding Current

| SIZE ( mm ) | KG PER PACKET | KG PER CARTON | In Amps   |
|-------------|---------------|---------------|-----------|
| 2.50 X 350  | 2             | 10            | 50 – 75   |
| 3.15 X 350  | 2             | 10            | 70 – 110  |
| 4.00 X 350  | 2             | 10            | 95 – 115  |
| 5.00 X 350  | 2             | 10            | 130 – 180 |