

**ROYAL 18 / 8 / 5 (E 18 : 8Mn R26)**

IS : 5206 E 18.8 Mn R 26

**Applications**

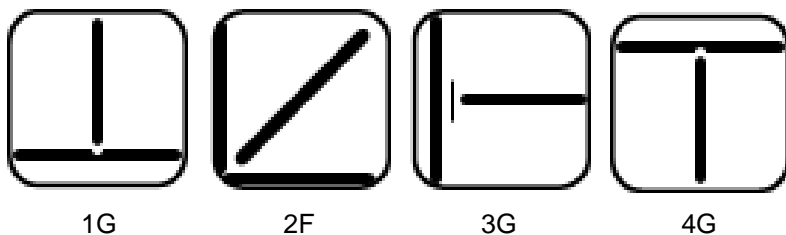
Suitable for joining ferritic to austenitic steels, Armour plates. Heat resistant steels, dissimilar materials. Buffers layers on difficult steels before hardfacing. Excellent for repairing cracks in austenitic manganese steel, castings for surfacing manganese steel.

**Characteristics on Usage**

It is a light-basic coated multi purpose stainless steel electrode with S.S. corewire, easy to operate in all position at low current. The weld metal has excellent crack resistance as well as heat resistance at 900° C. It is also corrosion resistant to atmosphere, marine water and weak acids. It gives 18% Cr, 8% Ni & 5% Mn type weld deposit, easily removable slag. It is to be dried at 250° C for 1 hour before welding.

**Notes On Usage**

- 1) Keep the arc as short as possible.
- 2) Remove dirt such as oil and dust from the groove.
- 3) Dry the electrode at 350°C for 60 Min. before use.

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

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.20 Max	5.0 - 8.0	0.90 Max	0.030 Max	0.040 Max	17.0 - 20.0	7.0 - 10.0	0.50

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION (L = 5d)
560 - 670	30 - 40

**Approvals**

RDSO IRSM - 28/86 Class M5

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	DC (+) / 70 OCV	50 - 75
3.15 x 350	2	10		80 - 110
4.00 x 350	2	10		110 - 150
5.00 x 350	2	10		150 - 200

**Packing**

Vaccum packing