

**ROYAL - 1A (E 308 - 16)**

AWS : SFA 5.4, E 308 - 16

IS : 5206 E 19.9R 26

**Applications**

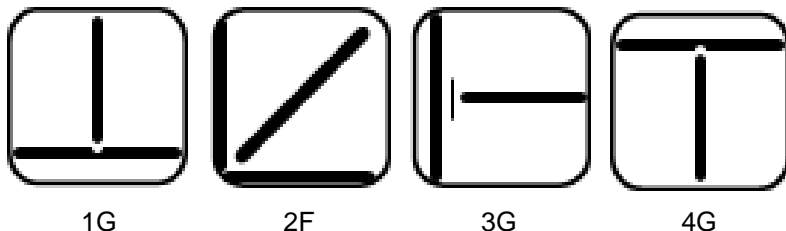
welding stainless steels of AISI 301, 302, 304 & 308 composition. For welding of household articles, milk & soap industries. Hospital apparatus, apparatus for nitric acid, acetic acid.

**Characteristics on Usage**

This is a normal carbon 19/9 stainless steel electrode with a controlled ferrite content of 3 to 7 % for maximum resistance to cracking, corrosion and high temperatures upto 800 Degrees centigrade. The metal has excellent creep strength and is of radiographic quality.

**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
0.080 Max	0.50- 2.50	1.00 Max	0.030 Max	0.040 Max	18.0 - 21.0	9.0 – 11.0	0.75

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 5d )	Reduction Area %	FERRITE %.
550 Min	35 % Min	50 – 70	3.0 – 8.0 %

**Approvals**

P.D.I.L., E.I.L., TOYO[TEIL] ,RDSO ,IBR, B.H.E.L.

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC 70 OCV / DC (+)	45 – 85
3.15 x 350	2	10		85 – 115
4.00 x 350	2	10		100 – 140
5.00 x 350	2	10		140 – 180

**Packing**

Vaccum packing