

**ROYAL - 1C (E 308L - 16)**

AWS : SFA 5.4, E 308L - 16

IS : E 19 - 9 LR - 16

**Applications**

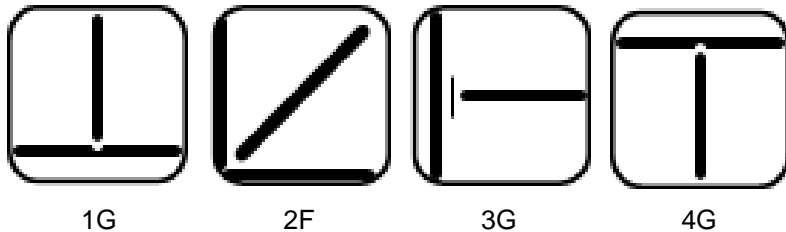
Ideally suited for welding of stainless steel of AISI grade 301, 302, 304, 304L, 308, 308L composition. For welding of household articles, milk and soap industries Hospital apparatus, nuclear plant.

**Characteristics on Usage**

An extra low carbon lime titania all position 19 Cr - 10 Ni stainless steel electrode which is highly resistance. intergranular corrosion, cracking, oxidation and scaling very smooth running with extremely smooth removal of slag leaving a uniform and fine rippled bead characterized by excellent all round performance and weld metal properties upto 250° C.

**Notes On Usage**

- ✍ 1) It is mostly effective to protect with welding, keeping the arc as short as possible in flat position .
- ✍ 2) Remove dirt such as oil and dust from 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 %
0.040 Max	0.50 - 2.0	0.75 Max	0.030 Max	0.040 Max	18.50 - 21.0	9.0 - 11.0

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
520	35 % Min

**Approvals**

N.P.C.I.L. , IOCL, KNPC, TPL

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / 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**

Vacuum packing