

ROYAL - 2A (E 316 - 16)

AWS : SFA 5.4, E 316 - 16

IS : 5206 E 19-11 - 2R 24

Applications

For welding all types of stainless steels. Tanks, coils & vats used in the pulp, paper & textile industry. Chemical mixers, paint, dye industries.

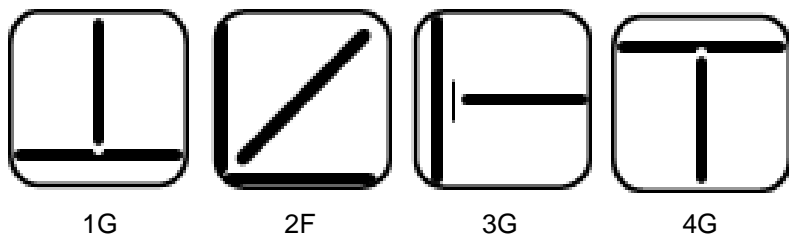
Characteristics on Usage

This is a rutile coated electrode, the weld metal has excellent creep strength and is of radiographic quality. It is capable of depositing 316 type of weld metal with normal content of carbon the electrode can be manipulated easily in all welding positions

Notes On Usage

1) Dry the electrode a 350°C for 60 Min- before use .

2) Keep the arc as short as possible.

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	0.03 Max	0.040 Max	17.0 - 20.0	11.0 - 14.0	2.0 -

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %	FERRITE %.
520 Min	30 % Min	3 - 8 %

Approvals

P.D.I.L., E.I.L., TOYO [TEIL]. ,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 / 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