

ROYAL CAST (Est.)

AWS A/SFA 5.15, Est.

Applications

It is used for welding Gears, Cracked motor or generators housing. It is used for repair works of cast iron, carbon steels, mild steels parts.

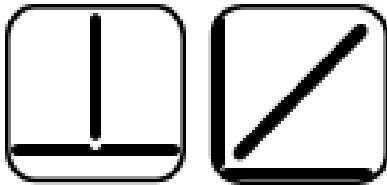
Characteristics on Usage

A medium heavy coated low hydrogen type electrode for all types of cast iron where machinability is not essential for welding basis on cast iron. It gives high strength where a strong and rigid joints is required in between two cast iron parts. Suitable for joining of cast iron to carbon and low alloy steels.

Notes On Usage

✍ 1) Preheat temperature vary in accordance with shape and size of base metal

✍ 2) Preheat at 200-350 °C gradual Cooling recommended after welding.

Welding Positions

1G

2F

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	60 - 80
3.15 x 350	5	20		100 – 140
4.00 x 450	5	20		140 – 180
5.00 x 450	5	20		180 – 230

Packing

Vaccum packing