ROYAL - 1B (E 347 - 16)

AWS : SFA 5.4, E 347 - 16
IS : 5206 E 19.9 Nb R26

Applications

AISI steels 321 and 347 generally on 18/8 steels stabilized by Titanium or Niobium in the manufacture of equipment for chemical , food & aircraft industries, also used for welding unstabilized stainless steels of AISI 301, 302, 304, & 308 types.

Characteristics on Usage

A lime titania all position electrode which is almost spatter free, has a smooth arc, with excellent weld bead finish and self lifting slag. A niobium stabilised stainless steel of 19 Cr - 10 Ni type weld metal has excellent creep strength and is of radiographic quality. Welding can be done on AC or DC (+) polarity, high degree of corrosion resistance in oxidising environment such as nitric acid.

Notes On Usage

- 1) Dry the electrode at 350°C for 60 Min- before use .
- 2) Keep the arc as short as possible.
- 3) Remove rust,water,oiland paint from the surface to be welded.

Welding Positions

1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Nb (Cb)+ Ta %
0.080 Max	0.50 - 2.50	1.00 Max	0.03 Max	0.040 Max	18.0 - 21.0	9.0 - 11.0	0.50 - 0.90

Mechanical Properties Of Weld Metal

U.T.S. (N/mm^2)	ELONGATION (L = 4d) %
520	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 X 350	2	10	4.40	22.05	45 – 80	AC / DC (+)
3.20 X 350	2	10	4.40	22.05	85 – 120	
4.00 X 350	2	10	4.40	22.05	100 – 140	
5.00 X 350	2	10	4.40	22.05	140 - 180	

Packing

Vaccum pack