

# ROYAL 5511

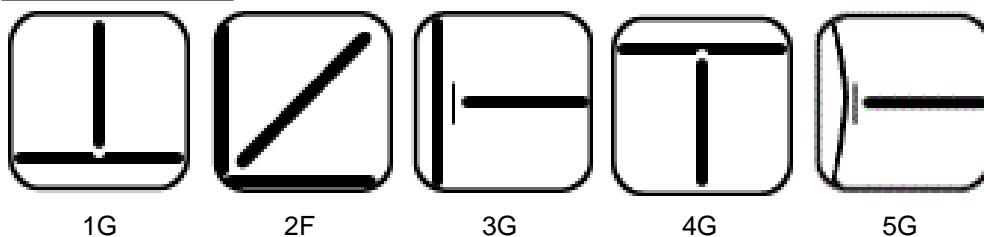
## Applications

Welding of monel and monel plated steels, joining of monel to steel, overlays of corrosion resistant monel on steel. Repairing defects in monel castings, used in fabrication, chemical food , dairy and pharmaceutical industries. Before surfacing stainless steel with Royal 5511 use Royal 5521 as buffer layer.

## Characteristics on Usage

Use a short arc do not weave the arc too wide. The base plate should be free from oil, grease and scale. Preheat the job between 100 -150 ° C depending on thickness.

## Welding Positions



## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
480-550 Min	30 - 35 %

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	60 – 80
3.15 X 350	2	10	75 - 100
4.00 X 350	2	10	100 – 140
5.00 X 350	2	10	140 – 180