

# ROYAL 5521

(Electrode for welding of inconel)

## TECHNICAL DATA

ALLOY BASIS : Ni, Mn, Cr, Fe, Nb.

APPLICATIONS : This is a versatile electrode for all position welding of Nickel, inconel monel, Nickel- Chromium –Iron alloys. HK alloys stainless and heat resisting steels. Also for welding dissimilar metals such as carbon steels. Stainless steels, Nickel and nickel alloys to each other. For use on equipment and components made of pure Nickel for fabrication of corrosion resistant tanks and containers, heat exchangers, furnace components, boilers, fittings etc.

PROPERTIES : The electrode gives soft stable arc on low currents. Deposits are cold tough and have excellent resistant to sealing at high temperature and corrosion resistance at both normal and elevated temperature. Also possess good thermal shock resistance.

PROCEDURE : Use a short arc and ensure minimum heat input , using lowest possible amperage and using stinger bead technique. To avoid crater cracks fill the crater properly.

WELDING CURRENT : DC (+)			
Size ( mm)	2.50	3.15	4.00
Current Range (Amps.)	40-60	60 - 80	100 – 140

U.T.S. of Joint : 550-600 N/mm<sup>2</sup>

Elongation : 30- 35 %

PACKING SPECIFICATIONS :

SIZE ( mm )	KG PER PACKET	KG PER BOX
2.50 X 350	2 Kg	10 Kg
3.15 X 350	2 Kg	10 Kg
4.00 X 350	2 Kg	10 Kg
5.00 X 350	2 kg	10 Kg

Manufactured in India By:

**ROYAL ARC ELECTRODES LTD.**

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