

**ROYAL CAST (Est.)**

AWS A/SFA 5.15, Est.

**Applications**

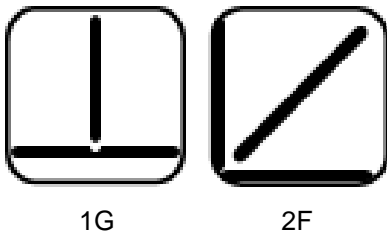
It is used for welding Gears, Cracked motor or generators housing. It is used for repair works of cast iron, carbon steels, mild steels parts.

**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 temprature vary in accordance with shape and size of base metal
- ✍ 2) Preheat at 200-350 °C gradual Cooling recommended after welding.

**Welding Positions****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