



!!!! WARNING !!!!



WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.

BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND MATERIAL SAFETY DATA SHEET (MSDS).

THE MATERIAL SAFETY DATA SHEET (MSDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE MSDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.

DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE MSDS.

SEE THE PRODUCT WARNING LABEL AND MSDS FOR COMPLETE WARNING INFORMATION.



Royal C276-20

Premium Nickel-Chromium-Moly Electrode

Typical Applications:

Royal C276-20 electrode is used primarily to weld various nickel-chromium-molybdenum alloys. These alloys are found in many pollution control, chemical processing, pulp and paper production, and waste treatment applications. **Royal C276-20** is also useful for various dissimilar joints involving nickel alloys, stainless steels and low alloy steels.

Specifications:

AWS A 5.11

E NiCrMo-4

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|--------------------|-------------|
| ➤ Tensile Strength | 100,000 PSI |
| ➤ Elongation | 25% |

Procedure:

Remove as much dirt, lubricants, grease, oil, paint and other processing residues as possible from the base metal. Use about 30% more opening than conventional joint openings to allow for the low penetrating and sluggish nature of the molten nickel. Use DC reverse polarity while holding the electrode about 20° off vertical for flat position welding.

Sizes:

3/32 40-65 AMPS

1/8 60-90 AMPS

5/32 90-125 AMPS