

Royal 300

Shielded Metal Arc Welding
(SMAW) Stick Electrode

Aluminum Alloy

DC reverse only
(DCEP)



"The Royal Line"

CROWN ALLOYS COMPANY

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Premium Extruded Coated Aluminum Electrode

Typical Applications

Royal 300 is THE universal aluminum electrode for arc welding sheet, cast and wrought aluminum alloys. Welds are strong, dense and free of porosity. **Royal 300** is suitable for both production and maintenance applications. The extruded flux coating yields less spatter, less fuming and an exceptionally stable and quiet arc at low amps. Ideal for welding heat treated aluminum parts. Even though the **Royal 300** was developed for arc welding aluminum, it can easily be used for oxy-acetylene brazing of aluminum as well.

Royal 300 is used to weld automotive, truck and bus parts. It is also used for aluminum tanks, pipes, ladders, shelves, refrigeration equipment and foundry patterns. **Royal 300** is often used to repair machining errors and build-up of missing sections of castings, extrusions and plates.

Specifications

- Tensile Strength Up to 34,000 psi
- Elongation % 15-25
- Machinability Excellent
- Color Match Good (will darken if anodized)
- Electrical Conductivity Good
- Corrosion Resistance Good

Procedure

Use DC reverse polarity (DCEP) only! Clean weld area thoroughly and bevel 1/8" or heavier sections to 70° - 90°. Preheating to 200°F - 300°F will remove harmful moisture and condensation AND greatly increase the wetting ability of the **Royal 300**. A short arc and fast travel speed should be maintained with the electrode tilted 5° in direction of travel. Use either stringer beads or a weaving technique. Remove slag between passes. Restart arc on existing weld deposits. Cool slowly. Chip off all slag before quenching. Clean with a 10% sulfuric acid and hot water solution if additional cleaning is required. Rinse with clean hot water.

Sizes, Amps and Part Numbers

Diameter	Amps	Part Numbers	
		1# Package	3# Package
3/32	50 – 100	RE300/EN-BP	RE300/EN
1/8	80 – 140	RE300/EO-BP	RE300/EO
5/32	100 – 175	RE300/EP-BP	RE300/EP



!!!! 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 THE NEW 16 SECTION SAFETY DATA SHEET (SDS).

THE SAFETY DATA SHEET (SDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE SDS 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 SAFETY DATA SHEET (SDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE SDS.

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

