

# Royal 200

Shielded Metal Arc Welding  
(SMAW) Stick Electrode

Carbon Steel

AC/DC  
All Position



*"The Royal Line"*

**CROWN ALLOYS COMPANY**

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## Premium All Purpose Electrode for Welding Carbon Steels in Any Position

### Typical Applications

**Royal 200** is excellent for welding sheet metal, plates, angle iron, beams, pipes and machine parts in all positions. It is perfect for maintenance where time does not permit proper fit up or cleaning. **Royal 200** has been designed to operate on any AC or DC welding machine even when the open circuit voltage is very low. The special alloyed flux coating of this electrode imparts a higher tensile strength and better cleaning action than most electrodes in this class. The low amperage requirement controls distortion when welding thin sheet metal and spatter is kept to a minimum. Because of its strong arc force and rapid solidification, **Royal 200** is ideal for overhead, vertical and any other kind of out-of-position welding. It is commonly used on applications requiring short, intermittent, and spot welds because of its outstanding restarting characteristics. In fact, its outstanding restart characteristics has led to the development of a carbon-tipped electrode that is just 1/16" in diameter!

### Specifications

- Tensile Strength Up to 80,000 psi
- Yield Strength Up to 68,000 psi
- Elongation in 2" 24 to 26%

### Procedure

Clean weld area as well as possible. Use DC reverse polarity (DCEP) on thick sections or use DC straight polarity (DCEN) on thin sections for limited penetration, less distortion and a flatter bead. Use AC to prevent arc blow. A medium arc length should be maintained with either stringer or weave beads. The slag usually peels away on its own, however, any left-over slag is easily removed with a light chipping hammer.

### Sizes, Amps and Part Numbers

Diameter	Amps	Part Numbers	
		1# Package	Standard Package
1/16	20 – 40	RE200/EL-BP	3 lb pkg RE200/EL
5/64	25 – 60	RE200/EM-BP	3 lb pkg RE200/EM
3/32	35 – 80	RE200/EN-BP	5 lb pkg RE200/EN
1/8	70 – 130	RE200/EO-BP	5 lb pkg RE200/EO
5/32	95 – 160	RE200/EP-BP	5 lb pkg RE200/EP
3/16	130 – 200	RE200/EQ-BP	5 lb pkg RE200/EQ



**!!!! 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.**

