

# ROYAL - CHROMAX ( )

## Applications

Suitable for rock crushers, Coal Mining cutters, charging rams, Dipper teeth, Shovel tracks, Tractor grousers, Pump housing, Conveyor rolls, Conveyor buckets, Crusher mantles, dredger cutter teeth Ignot lifting tongs etc.

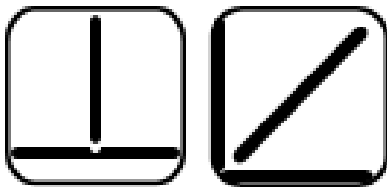
## Characteristics on Usage

A heavy – Coated electrode depositing semi austenitic weld metal which gives hardness approx 250 BHN in as welded condition. It is used for hard overlays on Mild Steel, Carbon Steel, low alloy steels and Austenitic Manganese Steel where resistance to combined effect of abrasion, impact and corrosion is necessary.

## Notes On Usage

1) Dry the electrodes at 150-200°C for 60 minute before use

## Welding Positions



1G

2F

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %
0.25 Max	2.50 – 3.50	0.20 – 0.50	0.03 Max	0.03 Max	17 – 20	4 - 5

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC/DC (+)	70 - 90
3.15 x 350	5	20		90 - 120
4.00 x 350	5	20		130 - 180
5.00 x 350	5	20		180 - 220