

ROYALFIL OA C III ()

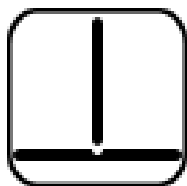
Applications

Suitable for surfacing of minerals craine wheels hot & cold punching dies metal cutting & forming tools, crush hammer & catter pillers trades, crane wheels, conveyer buckets. Self tempering deposit for hard facing applications in Mining & Civil Engineering industries.

Characteristics on Usage

A high carbon& high chrome self shielded fluxcored wire depositing a weld metal having excellent resistant of abrasion friction and moderate impact. A deposited weld metal gives Hardness 55 to 60 HRC.

Welding Positions



1G

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	Cr %	Mo %	V %
Spec. Reqd.	0.50-0.80	0.50-1.50	1.0 Max	4.0-8.0	1.0 Max	0.75 Max

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

55 – 60 HRC

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	180-250	26-30
1.60	210-280	26-30

Packing

15 kgs. vacuum packed plastic spool