

# ROYAL C – II

## Applications

Suitable for Shear's blades and croppers. Bamboo Chipper knives, coupling, Conveyer parts, Roller, Tractor wheels, Steel casting, Shafts, Axles.

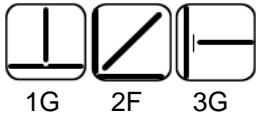
## Characteristics on Usage

A medium heavy coated rutile type good running hardfacing electrode, deposit a tough air hardening type of weld metal of approximately 350 BHN hardness. The weld metal is machinable and recommended for application involving maximum hardness as required.

## Notes On Usage

- 1) Dry the electrodes at 70-100°C for 60 minutes before use.
- 2) In case of hardfacing on large size cast steel, low alloy steel and high carbon steel preheat at 150°C and more than that in general.

## Welding Positions



## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %
0.30 Max	0.40 – 0.70	0.20 -0.40	0.030 Max	0.030 Max	2.50 – 3.50

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 X 350	5	20	11	44	70 - 100	AC / DC (+)
3.20 X 450	5	20	11	44	100 - 140	
4.00 X 450	5	20	11	44	140 - 180	
5.00 X 450	5	20	11	44	180 - 220	

HARDNESS ON IIIrd LAYER 330 -350 BHN APPROX.