

# ROYAL 7711

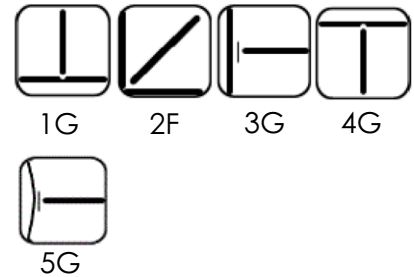
## Applications

To surface parts subject to heavy abrasive wear and mild impact: digger teeth, drills, conveyor screws, cutting and forming tools, punches, hot work dies, shear blades, crusher hammers, crane wheels, conveyor buckets & conveyor parts, plough-shares, cultivators, pulverisers, skids mixers, oil expeller worm, etc. Also manganese steel parts subject to high abrasion.

## Notes on Usage

- ☞ Clean the surface thoroughly. Remove cracked and spelled metal.
- ☞ It can be used for single and multipass hardfacing.
- ☞ Apply buffer layer with Royal – 1108 for multipass welding. Weld 3 layers if possible to attain recommended hardness.
- ☞ Slow cooling after welding is recommended using an oven or asbestos.

## Welding Positions



## Characteristics on Usage

Basic electrode with excellent welding characteristics. Economical for making hard overlays in all position. Gives regular beads. The deposit is hard, tough and free from porosities.

## Mechanical Properties Of Weld Metal

HARDNESS  
ON III rd LAYER

56 - 58 RC

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	80 - 130
3.15 X 350	2	10	90 - 180
4.00 X 350	2	10	140 - 230