

ROYALFIL GS C IV

Applications

Suitable for hard facing of loading machines, road machines, mixers, mixing rollers, digging tools, road machines, shovel teeth, different tools and wear parts etc

Characteristics on Usage

RoyalFil GS C IV is a gas shielded hard facing flux cored wire with high chromium content, about 9% Cr. Weld metal shows relatively good resistance to general corrosion and is highly wear resistant. Weld metal is also resistant to softening up to about 550 °C.

Welding Positions



Recommended Stick Out

20-40 mm

Shielding Gas

Carbon Dioxide (CO₂) shielding
Gas Flow: 20-25 Lit/Min
80% Ar+20% CO₂ shield
Gas Flow: ~- Li/Min

FLUX CORED WIRE : HARDFACING

Chemical Composition Of Weld Metal

C%	Mn%	Si%	Cr%
0.60	0.80	0.30	6.50

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

55 – 60 HRC

Packing and Welding Current

SIZE (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	180-250	26-32
1.60	210-280	26-32

Packing

15 kgs. vacuum packed plastic spool