

ROYALFIL OA 760

Applications

Hardfacing excavator parts, bucket, cutting edges grabteeth, crusher jaws & cones, table liner high chrome crusher rolls in cement plants, catalyst pipes and bends heavy load earth moving equipments etc.

Characteristics on Usage

RoyalFil OA 760 hard facing self shielded (Open Arc) fluxcored wire deposits high chromium high carbon weld metal subjected to hard facing of component for extreme abrasion / erosion under moderate / heavy impact load. The weld deposit is nonmachinable and grinding is possible.

Welding Positions



Recommended Stick Out
30-40mm

FLUX CORED WIRE : HARDFACING

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%
5.0	1.20	1.0	24-26

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

54 – 62 HRC

Packing and Welding Current

SIZE (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
2.40	250 - 400	26-32
2.80	250 - 400	26-32

Packing

Drum packing in 100Kgs / 250 Kgs.