

# ROYALFIL OA 760 (MOD)

## 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 (MOD) hard facing self shielded (Open Arc) fluxcored wire depositing 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 non machinable 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	1.00	0.50	24-26.50

## Mechanical Properties Of Weld Metal

HARDNESS  
ON III rd  
LAYER

54 – 60 HRC

## Packing and Welding Current

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

## Packing

15kgs Net wt vacuum packed plastic spool.