

ROYALFIL OA C II

Applications

It is for rebuilding of worn machinery parts, deposit surfaces are suitable for metal to metal rolling and sliding contact of low / high speed gear teeth shaft rail links rollers, wheel etc.in Mining & Civil Engineering industries.

Characteristics on Usage

A low alloyed self shielded fluxcored wire designed for building up crack free weld deposit and are machinable with carbide tipped tools. Deposited weld metal gives the hardness 30 – 40HRC.

Welding Positions



Recommended Stick Out

20-40 mm

FLUX CORED WIRE : HARDFACING

Chemical Composition Of Weld Metal

C%	Mn%	Si%	Cr%	Mo%
0.10-0.30	0.50-2.0	1.0 max	1.80-3.80	1.0 max

V%
0.35 max

Mechanical Properties Of Weld Metal

HARDNESS ON III rd LAYER
30 – 40 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