

ROYAL C – II

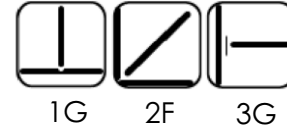
Applications

Suitable for Shear's blades and croppers. Bamboo Chipper knives, coupling, Conveyer parts, Roller, Tractor wheels, Steel casting, Shafts, Axles.

Characteristics on Usage

A medium heavy coated rutile type good running hardfacing electrode, deposit a tough air hardening type of weld metal of approximately 350 BHN hardness. The weld metal is machinable and recommended for application involving maximum hardness as required.

Welding Positions



Notes On Usage

- ⌚ Dry the electrodes at 70-100oC for 60 minutes before use.
- ⌚ In case of hardfacing on large size cast steel, low alloy steel and high carbon steel preheat at 150°C and more than that in general.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %
0.30 Max	0.40 – 0.70	0.20 -0.40	0.030 Max	0.030 Max	2.50 –3.50

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 x 350	5	20	11	44	70 - 100	AC / DC (+)
3.20 x 350	5	20	11	44	100 - 140	
4.00 x 350	5	20	11	44	140 - 180	
5.00 x 350	5	20	11	44	180 - 220	

HARDNESS ON IIIrd LAYER 330 -350 BHN APPROX.