

ROYAL C - V

Applications

Concrete mixer blades. Excavator teeth plough shares. Bucket lips, scraper blades. Cement die, rings.

Characteristics on Usage

This is a medium coated Rutile type hard facing electrode depositing on air hardening, weld metal is of approximately 600 BHN hardness. The weld metal resistant to severe abrasion and moderate impact, suitable for hardfacing applications like Dredger bucket lips, plough shares, excavator, conveyor buckets etc.,

Notes On Usage

- 1) Dry the electrodes at 70-100° C for 60 minute before use.
- 2) Preheat at 150° C or more than that in general.

Welding Positions



1G 2F

Chemical Composition Of Weld Metal

| C% | Mn% | Si% | S% | P% | Cr % |
|----------------|----------------|------------|-----------|-----------|----------|
| 2.20 – 2.80 | 0.80 – 1.25 | 2.50- 3.50 | 0.030 Max | 0.030 Max | 3.0– 4.0 |

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 - 90 | AC / DC (+) |
| 3.20 X 450 | 5 | 20 | 11 | 44 | 100 - 140 | |
| 4.00 X 450 | 5 | 20 | 11 | 44 | 140 - 180 | |
| 5.00 X 450 | 5 | 20 | 11 | 44 | 180 - 210 | |

TYPICAL WELD METAL HARDNESS IS 575 - 600 BHN.