

ROYAL C - III (L H)

Applications

Earth moving equipment, Conveyor buckets Oil expeller worms, Punching dies, Mine Rails Disintegrator hammers, shears blades, caterpillar treads Drill bits, Muller ploughs, Dipper teeth impellers Crane wheels, Cane cutting knives, Sprockets

Characteristics on Usage

This is medium heavy coated low hydrogen, air hardening type iron powder electrode. The weld deposit is extremely hard, sound and non-machinable. The low hydrogen enables the electrode to be used on high carbon and high sulphur steel without inducing under bead cracking or porosity. The electrode is recommended for hardfacing where severe conditions of abrasion and friction accompanied by moderate impact exist the weld deposit is finished by grinding.

Notes On Usage

- 1) Dry the electrodes at 350-400°C for 60 minutes before use
- 2) Preheat at 150°C and more than that in general

Welding Positions



1G 2F

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	V %	Mo %
0.40 – 0.75	0.50 – 0.70	0.60- 1.0	0.030 Max	0.030 Max	6.50– 7.80	0.40 – 0.80	0.70 –1.10

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	100 - 140	AC / DC (+)
3.20 X 450	5	20	11	44	140 - 180	
4.00 X 450	5	20	11	44	180 - 230	
5.00 X 450	5	20	11	44		

HARDNESS ON IIIrd LAYER IS 540 -600 BHN APPROX.