

ROYALFIL OA C II ()

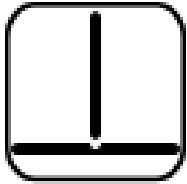
Applications

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



1G

Chemical Composition Of Weld Metal

| Element | C% | Mn% | Si% | Cr % | Mo % | V % |
|-------------|-----------|----------|---------|-----------|---------|----------|
| Spec. Reqd. | 0.10-0.30 | 0.50-2.0 | 1.0 max | 1.80-3.80 | 1.0 max | 0.35 max |

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

30 – 40 HRC

Welding Parameters (DC + VE)

| Diameter (mm) | Flat & Horizontal (A) | Flat & Horizontal (V) |
|------------------|-----------------------------|-----------------------------|
| 1.20 | 180-250 | 26-30 |
| 1.60 | 210-280 | 26-30 |

Packing

15 kgs. vacuum packed plastic spool