

ROYAL 7713

Applications

For joining manganese steel parts, hard facing of parts subject to heavy impact and stress. For use on big crushing equipment for rocks, jaws, cones, gyratory crushing mantles, excavator teeth, manganese rails etc.

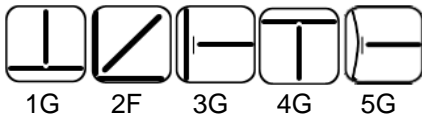
Characteristics on Usage

The deposit is work- hardening type and highly resistant to cracking and deformation during working. Excellent abrasion resistance in work- hardened condition. Prolonged working life even when subjected simultaneously to impact and abrasion.

Notes On Usage

- Ensure proper cleaning of area to be welded.
- Remove the fatigued area by gouging.
- Do not preheat manganese steel, inter pass temp. should be kept below 150 oC using staggered or skip welding .
- Hot peering helps reducing stress, cool slowly, for small components, immerse in water

Welding Positions



Mechanical Properties Of Weld Metal

HARDNESS ON III rd LAYER	Work To Hardness
45 - 55 RC	10 - 17 RC

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	18	70 - 120
3.15 X 350	2	18	150 - 190
4.00 X 350	2	18	170 - 250