**Applications**
Suitable for hard facing of loading machines, road machines, mixers, mixing rollers, digging tools, road machines, shovel teeth, different tools and wear parts etc.

**Characteristics on Usage**
RoyalFil GS C IV is a gas shielded hard facing flux cored wire with high chromium content, about 9% Cr. Weld metal shows relatively good resistance to general corrosion and is highly wear resistant. Weld metal is also resistant to softening up to about 550 °C.

**Welding Positions**
1G

**Recommended Stick Out**
15-20 mm

**Chemical Composition Of Weld Metal**

<table>
<thead>
<tr>
<th>Element</th>
<th>C%</th>
<th>Mn%</th>
<th>Si%</th>
<th>Cr %</th>
</tr>
</thead>
<tbody>
<tr>
<td>Typical</td>
<td>0.50</td>
<td>0.50</td>
<td>3.0</td>
<td>9.0</td>
</tr>
</tbody>
</table>

**Mechanical Properties Of Weld Metal**

**HARDNESS ON III rd LAYER**

54 – 59 HRC

**Welding Parameters (DC + VE)**

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Flat (A)</th>
<th>(V)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.20</td>
<td>180-210</td>
<td>26-30</td>
</tr>
<tr>
<td>1.60</td>
<td>210-250</td>
<td>26-30</td>
</tr>
</tbody>
</table>

**Shielding Gas**
Carbon Dioxide (CO2) shielding
Gas Flow :20-25 Lit / Min
80 % Ar + 20 % CO2 shielding
Gas Flow : 20-25 Lit/Min

**Packing**
15 kgs. vaccum packed plastic spool