

ROYALFIL GS C IV

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

Shielding Gas

Carbon Dioxide (CO₂) shielding

Gas Flow :20-25 Lit / Min

80 % Ar + 20 % CO₂ shielding

Gas Flow : 20-25 Lit/Min

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	Cr %
Typical Values	0.50	0.50	3.0	9.0

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

54 – 59 HRC

Welding Parameters (DC + VE)

Diameter (mm)	Flat	
	(A)	(V)
1.20	180-210	26-30
1.60	210-250	26-30

Packing

15 kgs. vaccum packed plastic spool