

# ROYALFIL OA 435

## Applications

Hard surfacing of continuous casting roll of steel plants, valves, Hardfacing of different kinds of shaft subjected to wear & corrosion of high temperature etc.

## Characteristics on Usage

Royal Fil OA - 435 is a martensitic type self shielded fluxcored welding Wire which are commonly used for hard surfacing of steel mill rolls, valve component of similar alloys. The weld metal is resistant to corrosion, erosion or abrasion & resistant to high temperature microstructure stability, thermal fatigue & cracking, eliminate ferrite in the microstructure.

## Welding Positions



1G

## Recommended Stick Out

30 - 40 mm

## Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	Cr %	Ni %	Mo %
Typical Values	0.080	1.00	0.60	13.50	4.00	0.50

## Mechanical Properties Of Weld Metal

HARDNESS  
ON III rd  
LAYER

42 – 48 HRC

## Welding Parameters (DC + VE)

Diameter (mm)	Flat (A)	Flat (V)
2.40 - 2.80	250-400	26-32

## Packing

10 Kgs. vaccum packed plastic spool