

# ROYALFIL OA 725

## Applications

It is used for railway, rails & crossover rebuilding, shafts, rollers, wheels & in Mining & Civil Engineering Industries.

## Characteristics on Usage

Royal Fil OA - 725 is a self shielded chromium alloyed fluxcored wire gives chromium, Moly & Manganese type weld deposit.

## Welding Positions



1G

## Recommended Stick Out

30 – 40 mm

## Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	Cr %
Typical Values	0.40	16.00	0.50	14.00

## Mechanical Properties Of Weld Metal

HARDNESS ON III rd LAYER	Work To Hardness
22-24 HRC	44-48 HRC

## Welding Parameters (DC + VE)

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

## Packing

10 Kgs. vacuum packed plastic spool