Applications
Rebuilding & reclamion of chain guide rolls, wheels, worn out parts of bulldozers, shaft rollers in mining & civil engineering industries.

Characteristics on Usage
RoyalFil OA - 730 is a low alloy air hardening type self shielded fluxcored wire designed for rebuilding & reclamion of chain guide rolls, wheels, worn out parts of bulldozers, shaft rollers in Mining & Civil Engineering Industries.

Welding Positions

Supported Welding Positions

1G

Recommended Stick Out

30 – 40 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 Values</td>
<td>0.15</td>
<td>1.50</td>
<td>0.80</td>
<td>1.50</td>
</tr>
</tbody>
</table>

Mechanical Properties Of Weld Metal

HARDNESS ON III rd LAYER

25-35 HRC

Welding Parameters (DC + VE)

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Flat (A)</th>
<th>(V)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.40 – 2.80 mm</td>
<td>250-400</td>
<td>26-32</td>
</tr>
</tbody>
</table>

Packing

10 Kgs. vacuum packed plastic spool