

ROYALFIL OA 760

Applications

Hardfacing excavator parts, bucket, cutting edges grabteeth, crusher jaws & cones, table liner high chrome crusher rolls in cement plants, catalyst pipes and bends heavy load earth moving equipments etc.

Characteristics on Usage

RoyalFil OA 760 hard facing self shielded (Open Arc) fluxcored wire deposits high chromium high carbon weld metal subjected to hard facing of component for extreme abrasion / erosion under moderate / heavy impact load. The weld deposit is nonmachinable and grinding is possible.

Welding Positions



1G

Recommended Stick Out

30- 40 mm

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	Cr %
Typical Values	5.0	1.20	1.0	24-26

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

56 – 62 HRC

Welding Parameters (DC + VE)

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

Packing

10 Kgs. vaccum packed plastic spool