Applications
Blast furnace hoppers, extractor fans, crushers jaws mixer blades, sinter brakers, ventilator blades.

Characteristics on Usage
RoyalFil OA - 765 is a self shielded fluxcored wire with high alloyed Chromium cast iron with a high concentration of complex carbide weld deposit. It gives abrasive wear resistance upto 600°C.

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>
<th>V %</th>
<th>Mo %</th>
<th>W%</th>
<th>Nb (Cb)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Typical Values</td>
<td>5.50</td>
<td>0.50</td>
<td>1.50</td>
<td>22.00</td>
<td>1.00</td>
<td>5.50</td>
<td>2.00</td>
<td>6.00</td>
</tr>
</tbody>
</table>

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd LAYER
63 – 65 HRC

Welding Parameters (DC + VE)

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Flat (A)</th>
<th>Flat (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