

ROYALFIL OA 765

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

Element	C%	Mn%	Si%	Cr %	V %	Mo %	W%	Nb (Cb)
Typical Values	5.50	0.50	1.50	22.00	1.00	5.50	2.00	6.00

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

63 – 65 HRC

Welding Parameters (DC + VE)

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

Packing

10 Kgs.vaccum packed plastic spool