Applications
It is used for rebuilding of cement, crusher, roll, pulveriser rolls and hammer.

Characteristics on Usage
RoyalFil OA - TIC is a self shielded hardfacing fluxcored wire gives chromium carbide type weld deposit which is expose to high abrasive wear & impact stress.

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>Mo %</th>
<th>Ti %</th>
</tr>
</thead>
<tbody>
<tr>
<td>Typical Values</td>
<td>2.00</td>
<td>1.50</td>
<td>1.00</td>
<td>7.00</td>
<td>1.40</td>
<td>5.00</td>
</tr>
</tbody>
</table>

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd LAYER
56 – 58 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