

ROYALFIL OA TIC

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

Element	C%	Mn%	Si%	Cr %	Mo %	Ti %
Typical Values	2.00	1.50	1.00	7.00	1.40	5.00

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

56 – 58 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