

## ROYAL C – II

### Applications

Suitable for Shear's blades and croppers. Bamboo Chipper knives, coupling, Conveyer parts, Roller, Tractor wheels, Steel casting, Shafts, Axles.

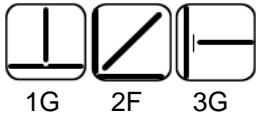
### Characteristics on Usage

A medium heavy coated rutile type good running hardfacing electrode, deposit a tough air hardening type of weld metal of approximately 350 BHN hardness. The weld metal is machinable and recommended for application involving maximum hardness as required.

### Notes On Usage

- 1) Dry the electrodes at 70-100°C for 60 minutes before use.
- 2) In case of hardfacing on large size cast steel, low alloy steel and high carbon steel preheat at 150°C and more than that

### Welding Positions



### Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %
0.30 Max	0.40 – 0.70	0.20 -0.40	0.030 Max	0.030 Max	2.50 – 3.50

### Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	70 - 100
3.15 x 450	5	20		100 - 140
4.00 x 450	5	20		140 - 180
5.00 x 450	5	20		180 - 220

HARDNESS ON IIIrd LAYER 330 -350 BHN APPROX.