

ROYAL - CHROMANG

Applications

It is ideally suitable for Dipper teeth, Charging rams, Tractor grousers, Dipper lips, Pump housing, Conveyor rolls, Conveyor buckets, Mill hammer, Scraper blades, Pulverizes plows, and pump impeller's.

Characteristics on Usage

It is a heavy coated hard surfacing electrode with pleasing performance for overlays on Mild Steel. Carbon steel, low Alloy steels, and austenitic Manganese steels. The weld deposit gives hardness up to 200 BHN approx and work hardness approx 500 BHN. The weld metal is excellent resistance to combined effect of impact, abrasion and corrosions.

Notes On Usage

➤ 1) Dry the electrodes at 350-400°C for 60 minute before use

Welding Positions



1G 2F

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %
0.25 Max	5.50 Max	0.50 Max	0.030 Max	0.030 Max	16.5 Max

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
3.15 x 350	5	20	AC/DC (+)	90 - 120
4.00 x 350	5	20		130 - 160
5.00 x 350	5	20		180 - 220

HARDNESS : 250 BHN approx as welded condition and increasing to 500 BHN approx & impact in service.