

ROYAL - CHROMAX

Applications

Suitable for rock crushers, Coal Mining cutters, charging rams, Dipper teeth, Shovel tracks, Tractor grousers, Pump housing, Conveyor rolls, Conveyor buckets, Crusher mantles, dredger cutter teeth Ignit lifting tongs etc.

Characteristics on Usage

A heavy – Coated electrode depositing semi austenitic weld metal which gives hardness approx 250 BHN in as welded condition. It is used for hard overlays on Mild Steel, Carbon Steel, low alloy steels and Austenitic Manganese Steel where resistance to combined effect of abrasion, impact and corrosion is necessary.

Notes On Usage

➤ 1) Dry the electrodes at 150-200°C for 60 minute before use

Welding Positions



Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %
0.25 Max	2.50 – 3.50	0.20 – 0.50	0.03 Max	0.03 Max	17 – 20	4 - 5

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 - 90
3.15 x 350	5	20		90 - 120
4.00 x 350	5	20		130 - 180
5.00 x 350	5	20		180 - 220

HARDNESS : As deposited weld metal gives 250 BHN approx & rises to 400 BHN under heavy peering and to Peering and to 500 BHN approx under heavy impact in service.