

ROYAL 7711

Applications

To surface parts subject to heavy abrasive wear and mild impact: digger teeth, drills, conveyor screws, cutting and forming tools, punches, hot work dies, shear blades, crusher hammers, crane wheels, conveyor buckets & conveyor parts, plough-shares, cultivators, pulverisers, skids mixers, oil expeller worm, etc. Also manganese steel parts subject to high abrasion.

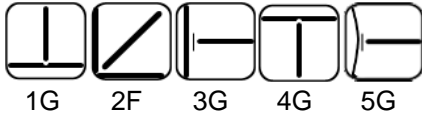
Characteristics on Usage

Basic electrode with excellent welding characteristics. Economical for making hard overlays in all position. Gives regular beads. The deposit is hard, tough and free from porosities.

Notes On Usage

- Clean the surface thoroughly. Remove cracked and spalled metal.
- It can be used for single and multipass hardfacing.
- Apply buffer layer with Royal – 1108 for multipass welding. Weld 3 layers if possible to attain recommended hardness.
- Slow cooling after welding is recommended using an oven or asbestos.

Welding Positions



1G 2F 3G 4G 5G

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

56 - 58 RC

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	80 - 130
3.15 X 350	2	10	90 - 180
4.00 X 350	2	10	140 - 230