

ROYAL C – I (E Fe A)

IS: 7303. 1974 Class – E Fe A

Applications

Suitable for Gears, Shafts, Axles, Hammers, Pinion teeth, Pulleys, Couplings, Spindles.

Characteristics on Usage

A medium heavy coated rutile type all position hard surfacing electrode. It deposits a tough air hardening type of weld metal approximately 250 BHN hardness. The weld metal is machinable and recommended for hard surfacing on hard base material. The electrodes give low smoke and negligible spatter with smooth arc characteristics.

Notes On Usage

- 1) Dry the electrodes at 70-100 °C for 60 minutes before use.
- 2) Hard facing large size cast steel and forging low alloy steel and high carbon steel requires preheating at 150°C and more than that.

Welding Positions

1G

2F

3G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Mo %
0.16 Max	0.15 – 0.40	0.25 Max	0.030 Max	0.030 Max	0.4 – 0.75	1.00 – 1.50

Packing and Welding Current

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