

ROYAL 7710

Applications

Surfacing of parts subject to wear or impact rims, carbon – alloyed rails, dies, striking tools, rolling surfaces, sliding surfaces subject to heavy wear, matrixes, stampers etc. Also, ideally suited for construction machinery parts like tractor sprockets, rollers, concrete mixes blades, pump shafts and conveyor screws. The right choice for providing buffer layer where impact and abrasion occur together.

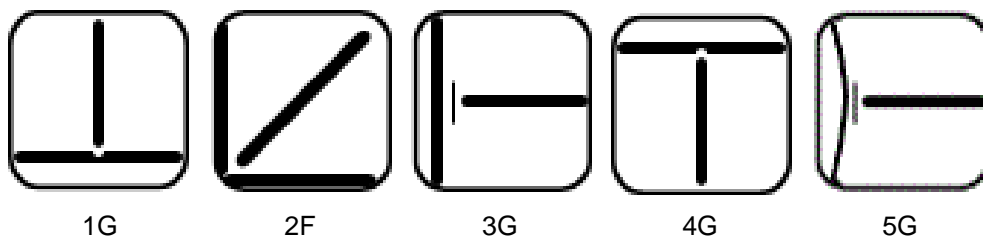
Characteristics on Usage

Basic all position electrode. The deposit is particularly resistant to impact. Thick surfacing without intermediate layers possible

Notes On Usage

- ✍ Clean the surface thoroughly. Remove cracked and spelled 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



Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

29-35 RC

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
3.15 X 350	2	10	80 - 110
4.00 X 350	2	10	110 - 160
5.00 X 350	2	10	140-180