

ROYAL 7738

Applications

Resistant to heavy loads produced during crushing of canes. Smooth and stable arc, even in positional welding, provides faster due build-up due to high deposition rate. Excellent deposition with an aggressive "Spray type" arc permits its use even while the rolls are in operation; imparts better grip to canes being crushed, thus increasing the efficiency and productivity of the sugar mills.

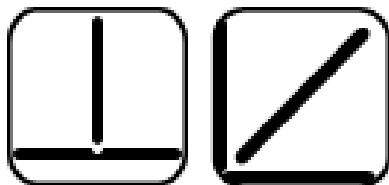
Characteristics on Usage

Royal 7738 is to be used on the crushing rolls in operation at a speed of 4-8 RPM. Deposit on the side walls of the groove with the electrode in contact position. Position electrode 30° below the horizontal line and in direction of the movement of the roll. Royal 7738 can be applied directly on the sugar impregnated surfaces.

Notes On Usage

- ✍ Use a medium / long arc, to prevent excessive dilution with parent metal. Use low amperage.
- ✍ The recommended hardness is obtained in the second or third layer.

Welding Positions



1G

2F

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

59-61 RC

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	In Amps
3.15 X 350	2	10	80 - 120
4.00 X 350	2	10	120 - 160