

ROYALFIL GS C IV ()

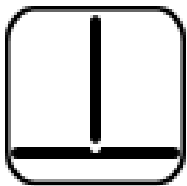
Applications

Suitable for hard facing of loading machines, road machines, mixers, mixing rollers, digging tools, road machines, shovel teeth, different tools and wear parts etc

Characteristics on Usage

RoyalFil GS C IV is a gas shielded hard facing flux cored wire with high chromium content, about 9% Cr. Weld metal shows relatively good resistance to general corrosion and is highly wear resistant. Weld metal is also resistant to softening up to about 550 °C.

Welding Positions



1G

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	Cr %
Typical Values	0.60	0.80	0.30	6.50

Mechanical Properties Of Weld Metal

HARDNESS
ON III rd
LAYER

54 – 60 HRC

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	180-210	26-30
1.60	210-250	26-30

Packing

15 kgs. vacuum packed plastic spool