

Royal 240

Shielded Metal Arc Welding
(SMAW) Stick Electrode

Hard-Facing Alloy

AC/DCEP
All Position
(Except Vertical Down)



"The Royal Line"

CROWN ALLOYS COMPANY

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Premium Hard-Facing Electrode for High Abrasion and Medium Impact

Typical Applications

Royal 240 is a premium hard surfacing electrode for use on worn conveyor and press screws, bucket teeth and lips, slurry pumps, mixer wings, hammer mill parts, plow shares, dredger teeth, coal augers, agitators, earth augers and scrapers. The **Royal 240** will provide a hard surface on any ferrous part that is subjected to severe abrasion. It will even resist moderate impact forces on all metal to earth applications such as equipment used in the processing of soil, rock, coal, cement and ceramic matter. Because the **Royal 240** has a high chromium content, it will resist abrasion and scaling even at elevated temperatures which makes it the ideal choice for open hearth tools, grates and conveying chains in annealing furnaces and manipulators. The smooth arc action and smooth bead of this rod makes it easy to control the amount of weld deposit.

Specifications

- Hardness 57 – 61 (Rockwell C) as welded

Procedure

Clean area to be surfaced. Remove foreign material and unsound metal from surface to be welded. Set the machine on AC or DC reverse polarity (DCEP). A weave bead technique is the easiest way to apply this electrode. When applying the final pass, keep the electrode vertical to the work piece and maintain a short arc. Deposits should be limited to two passes. If more build-up is required, the first passes should be made with **Royal 235** (for carbon steels or manganese steels) or **Royal 290** (for cast iron). To prevent excessive local heat build-up in the part, alternate the welding area. Allow part to cool slowly.

Sizes, Amps and Part Numbers

| Diameter | Amps | Part Numbers | |
|----------|-----------|--------------|------------|
| | | 1# Package | 5# Package |
| 1/8 | 80 - 125 | RE240/EO-BP | RE240/EO |
| 5/32 | 100 - 160 | RE240/EP-BP | RE240/EP |
| 3/16 | 125 - 190 | RE240/EQ-BP | RE240/EQ |



!!!! WARNING !!!!



WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.

BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND THE NEW 16 SECTION SAFETY DATA SHEET (SDS).

THE SAFETY DATA SHEET (SDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE SDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.

DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE SDS.

SEE THE PRODUCT WARNING LABEL AND SDS FOR COMPLETE WARNING INFORMATION.

