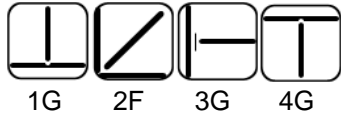


Applications

Used for fabrication in chemical plant machinery structures & steel fabrication in ship building, heavy bridges, towers, earth moving equipments etc.

Characteristics on Usage

RoyalFil Dual T9R is all position flux cored wire having ability to produce higher deposition rates using CO₂ or Ar+CO₂ shielding. Weld metal is consistently free of inclusions, porosity & is of radiographic quality. The wire is formulated to produce less fumes & minimum spatters. Slag coverage is complete & gets removed very easily. Designed for single pass & multiple pass welding of low & medium carbon steels with improved impact properties. Meets the new AWS A 5.20 'D' designation requirements.

Welding Positions

1G 2F 3G 4G

Recommended Stick Out

15 - 20 mm

Shielding GasCarbon Dioxide (CO₂) shielding

Gas Flow :20-25 Lit / Min

80 % Ar + 20 % CO₂ shielding

Gas Flow : 20-25 Lit/Min

Chemical Composition Of Weld MetalTypical Values * Under CO₂ Shield; ** 80% Argon + 20% CO₂ Shield

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values *	0.045	1.25	0.40	0.010	0.018	0.40
Spec. Req. *	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max
Typical Values **	0.055	1.55	0.50	0.010	0.018	0.40
Spec. Req. **	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max

Mechanical Properties Of Weld MetalTypical Values * Under CO₂ Shield; ** 80% Argon + 20% CO₂ Shield

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
Typical Values*	580	490	26	60
Spec. Reqd.*	490- 670	390 Min	22 Min	27 Min
Typical Values **	600	515	26	80
Spec. Reqd.**	490-670	390 Min	22 Min	27 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	180-210	26-30	150-210	22-26	180-210	26-30
1.60	210-250	26-30	180-250	21-27	210-250	26-30

Packing

15 kgs. vaccum packed plastic spool.