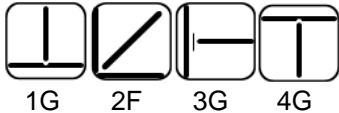


**Applications**

Royalfil GS-15RB is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-525-70, and C grades of SA-285, IS: 2002-2A & 2B IS2062, IS226 & DIN 17155 HIV e.g. Construction of bridges, Pressure vessel & Offshore structures.

**Characteristics on Usage**

Royalfil GS-15RB is an all position basic type flux cored wire-having stable and smooth arc with good slag detachability using CO<sub>2</sub> shield. The slag coverage is complete and easy to remove. Weld metal is consistently free of inclusions and porosity for radiography soundness. This wire is formulated to have high resistance to cracking with fewer fumes & minimal spatter.

**Welding Positions**

1G 2F 3G 4G

**Recommended Stick Out**

15-20 mm

**Shielding Gas**

Carbon Dioxide (CO<sub>2</sub>) shielding  
Gas Flow :20-25 Lit / Min

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values	0.050	1.25	0.45	0.010	0.018	0.40
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT ( CVN ) AT - 30° C ( J )
Typical Values	550	470	26	60
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

**Approvals**

IBR

**Packing**

15 kgs. vacuum packed plastic spool.