

**Applications**

Royalfil GS-11R is for mass production in a wide range in mild and low alloy steels. Suitable for joining steels conforming to ASTM SA-36/SA-36M and A, B, C, D grades of SA-283 / SA-283M. Examples:- Fabrication in chemical plant machinery structures & Steel frames in ship building, heavy bridges & towers.

**Characteristics on Usage**

Royalfil GS-11R is Rutile flux cored wire designed for optimum performance in flat and horizontal positions when using CO<sub>2</sub> shielding. The slag coverage is complete and designed for easy removal with fewer fumes, minimal spatter in flat and horizontal positions. Weld metal is of radiographic quality.

**Welding Positions**

1G 2F

**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%
Typical Values	0.05	1.25	0.38	0.010	0.018
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 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 ) %	CVN IMPACT AT - 20°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 & Horizontal	
	(A)	(V)
1.20	180-210	26-30
1.60	210-250	26-30

**Packing**

15 kgs. vacuum packed plastic spool.