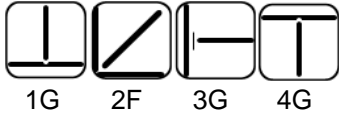


Applications

Royalfil GS -12H4R is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-36 /SA-36M and A,B,C,D grades of SA-283 / SA-283M & SA-414 / SA-414M.(P.No.1) e.g. Fabrication in chemical plant machinery structures & Steel frames in ship building, heavy bridges & towers.

Characteristics on Usage

Royalfil GS-12H4R is low hydrogen all position Rutile flux cored wire designed for optimum performance when using CO₂ shield. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce fewer fumes, minimal spatter.

Welding Positions

1G 2F 3G 4G

Recommended Stick Out

15 - 20mm

Shielding GasCarbon Dioxide (CO₂) 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 ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 20°C (J)
Typical Values	550	470	27	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

Packing

15 kgs. vaccum packed plastic spool.