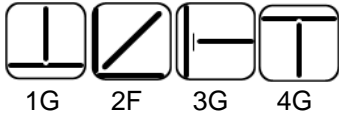


Applications

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

Characteristics on Usage

Royalfil GS-T9R is all position Rutile flux cored wire having ability to produce higher deposition rates using 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 Gas

Carbon Dioxide (CO₂) shielding
Gas Flow :20-25 Lit / Min

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values	0.045	1.25	0.40	0.010	0.018	0.40
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.5 Max

Mechanical Properties Of Weld Metal

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

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. vacuum packed plastic spool.