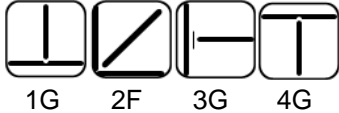


Applications

Suitable for single & multiple pass welding using DCEP polarity. It is used for welding of similar composition of MO steels & other creep resistant steels with Co₂ shielding .Commonly used in steam power plants, marine, chemical plants & refineries.

Characteristics on Usage

RoyalFil GS 15B - A1 is Basic type low alloy steel all position welding wire with less spatter, smooth & stable arc, with good penetration & easily removable thin slag. Weld metal is of radiographic quality with low temp. toughness as down to -30°C.

Welding Positions

1G 2F 3G 4G

Recommended Stick Out

15 - 20mm

Shielding Gas

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

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Mo %
Typical Values	0.050	1.00	0.45	0.010	0.018	0.50
Spec. Reqd.	0.12 Max	1.25 Max	0.80 Max	0.030 Max	0.030 Max	0.4 -0.65

Mechanical Properties Of Weld Metal

(After PWHT at 620°C for 1 Hr)

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
Typical Values	550	460	25	50
Spec. Reqd.	490 - 620	400 Min	20 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.