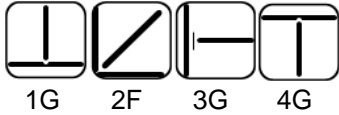


**Applications**

Royalfil-18R is designed for welding atmospheric corrosion resistant steel as Resco, corton & ITACOR. Suitable for joining weathering grade steels conforming to ASTM SA-588, SA-242 etc.

**Characteristics on Usage**

Royalfil GS-18R is Rutile base all position flux cored wire for welding of low alloy. This wire is having stable and smooth arc with good slag detachability & excellent bead appearance with CO<sub>2</sub> shield. This wire is designed for welding CORTON grade weather resistance steels.

**Welding Positions****Recommended Stick Out**

15 - 20mm

**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%	Cr %	Ni %	Cu %
Typical Values	0.05	0.97	0.45	0.01	0.018	0.62	0.65	0.40
Spec. Reqd.	0.12 Max	0.50 -1.30	0.35 -0.80	0.03 Max	0.03 Max	0.45- 0.70	0.40-0.80	0.30-0.75

**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	600	510	25	50
Spec. Reqd.	550-690	470 Min	19 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**

RDSO-IRS CLASS IV

**Packing**

15 kgs. vaccum packed plastic spool.