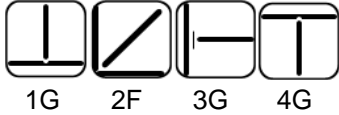


Applications

Royalfil-GS-38R is all position welding wire suitable for single & multiple pass welding of high tensile steel used in machinery, structures bridges, low temperature service steel in the construction of LPG,LNG storage tanks etc. Steels welded are Hy80, Hy100. ASTM A 710, ASTM A 514 and similar high strength steels.

Characteristics on Usage

Royalfil GS-38R is a all position low alloy rutile base flux cored wire depositing approximately 1.0-2.0% Ni & 0.20%Mo weld metal with CO2 shielding. The slag coverage is complete and easy to remove. Weld metal is consistently free of inclusions and porosity with very good mechanical strength & is of radiographic quality.

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%	Cr %	Ni %	Mo %
Typical Values	0.050	1.20	0.40	0.010	0.018	0.10	1.50	0.20
Spec. Reqd.	0.15 Max	0.50 -1.75	0.80 Max	0.03 Max	0.03 Max	0.15 Max	1.00 -2.00	0.35 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	620	530	24	60
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

Packing

15 kgs. vaccum packed plastic spool.