

Applications

Royalfil GS-41B is suitable for welding of many HSLA steels like HY-80, Naxtra 56, 63, LA60 etc. Suitable for joining steels conforming to ASTM Grade 60, Grade 65 steel of SA-515/ SA-515M Grade 55, Grade 60, Grade 65 steels of SA-516/SA-516M, all thickness range of SA- 455/SA-455M etc.

Characteristics on Usage

Royalfil GS-41B is basic flux cored wire having stable and smooth arc with good slag detachability. It is used for flat & horizontal welding with CO₂ shield. Weld metal is of radiographic quality.

Welding Positions

1G 2F

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%	Cr %	Ni %	Mo %
Typical Values	0.05	1.45	0.45	0.01	0.018	0.10	1.80	0.30
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 – 50 ° C (J)
Typical Values	705	590	20	50
Spec. Reqd	620-760	540 Min	17 Min	27 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal	
	(A)	(V)
1.20	180-210	26-30
1.60	210-250	26-30

Packing

15 kgs. vaccum packed plastic spool.