

Applications

Royalfil GS-41B3 is designed for welding of creep-resisting 2.25% Cr & 1% Mo steel in flat and horizontal position. It is used for welding of high temperature, creep resistant Cr-Mo alloy boiler plates, pressure pipes and other pressure vessel applications. Suitable for joining steels conforming to ASTM Grade F22 of SA-182/ SA-182M & SA-336/ SA-336M, Grade T4, T22 of SA-199 / SA-1995M, Grade P22 of SA-335/SA-335M etc.

Characteristics on Usage

Royalfil GS-41B3 is basic flux cored wire having stable and smooth arc with good slag detachability. This wire is designed for welding of creep-resisting 2.25% Cr & 1% Mo steels. It is used for flat & horizontal welding with CO₂ shield. Weld metal is of radiographic quality.

Welding Positions

1G 2F

Recommended Stick Out

15 - 20mm

Shielding GasCarbon Dioxide (CO₂) shielding
Gas Flow :20-25 Lit / Min**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Mo %
Typical Values	0.06	1.05	0.35	0.01	0.018	2.25	1.00
Spec. Reqd	0.05 -0.12	1.25 Max	0.80 Max	0.03 Max	0.03 Max	2.00-2.50	0.90-1.20

Mechanical Properties Of Weld Metal

(After PWHT at 690 ± 15°C for 1 Hr)

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	675	605	20
Spec. Reqd.	620-760	540 Min	17.0 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. vacuum packed plastic spool.