

Applications

It is primarily intended for as welded applications for welding wire low alloy high strength steels. Addition of approximately 0.50Cr provides higher strength for many applications needing in excess of 830 N/ mm² tensile strength such as "armour" plate. Typical applications include welding of Hy 100 and ASTM A 514 steels.

Characteristics on Usage

RoyalFil GS 43R is Rutile base low hydrogen type flux cored wire designed for single and multiple pass welding in flat and horizontal positions with CO₂ shielding. 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	0.050	1.40	0.50	0.010	0.015	0.50	2.00	0.30
Spec. reqd.	0.15 Max	1.20-2.25	0.80 Max	0.030 Max	0.030 Max	0.20-0.65	1.75-2.60	0.20-0.65

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 20°C (J)
Typical Values	830	740	20	60
Spec. reqd.	760-900	680 Min	15 Min	27Min

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.