

Applications

For welding of high strength fine grain structured steel having yield strength around 750 N/mm²

Characteristics on Usage

RoyalFil GS - 45R is Rutile base flux cored wire for flat & horizontal position welding. It gives stable arc easily detachable slag, uniform bead & less spatters 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	0.050	1.70	0.45	0.010	0.015	1.00	2.20	0.50
Spec. Reqd.	0.12 Max	1.50-1.80	0.80 Max	0.030 Max	0.030 max	0.80-1.30	2.00-2.50	0.40-0.65

Mechanical Properties Of Weld Metal

Property	U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
	(N/mm ²)	(N/mm ²)	(L = 4d) %	AT - 30° C (J)
Typical Values	900	810	18	50
Spec.Reqd.	830 Min	745 Min	14 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.