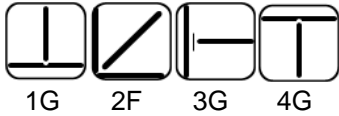


Applications

Royalfil-GS-91D is used for welding steel to IS 8500-91 grade 540B and 590B, IS 2002-92 grade III, IS:1875-92 class III A or other equivalent steel.

Characteristics on Usage

Royalfil GS-91 D is all position flux cored wire for welding of low alloy steel, Carbon – Moly steel. It gives stable and smooth arc with good slag detachability & excellent bead finish with radiographic quality with CO₂ shielding.

Welding Positions

1G 2F 3G 4G

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%	Mo %
Typical Values	0.050	1.67	0.60	0.010	0.018	0.50
Spec. Reqd.	0.12 Max	1.25- 2.00	0.80 Max	0.030 Max	0.030 Max	0.25 - 0.55

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT -40 °C (J)
Typical Values	670	580	24.0	50
Spec. Reqd.	620 - 760	570 Min	17 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

Approvals

RDSO, IRS CLASS III

Packing

15 kgs. vacuum packed plastic spool.