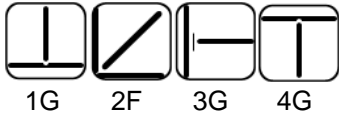


**Applications**

Royalfil-GS-91R fcw wire is used for high tensile, fine grain structural steel, creep resistant fine grain structural steels, heat treated fine grain structural steel.

**Characteristics on Usage**

Royalfil GS-91 R is Rutile base gas shielded flux cored wire welding for all position welding with Co2 shielding depositing radiographic quality metal. Arc is smooth & stable with low spatter and good bead appearance.Slag.

**Welding Positions**

1G 2F 3G 4G

**Recommended Stick Out**

15 - 20mm

**Shielding Gas**

Carbon Dioxide (CO<sub>2</sub>) shielding  
Gas Flow :20-25 Lit / Min

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Ni %	Mo %
Typical Values	0.065	1.40	0.35	0.008	0.018	1.20	0.40
Spec. Reqd.	0.05 - 0.08	1.20-1.60	0.25-0.40	0.03 Max	0.03 Max	1.0-1.40	0.3-0.50

**Mechanical Properties Of Weld Metal**

Property	U.T.S.	Y.S.	ELONGATION	IMPACT ( CVN )
	(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT - 30° C ( J )
Typical Values	670	590	22	80
Spec. Reqd.	620 Min.	540 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

**Packing**

15 kgs. vaccum packed plastic spool.