

**Applications**

It is used for welding of medium & high tensile steel with mixed gas 80%Ar+ 20% Co2 shielding in ship building, machineries, structural fabrication and bridge constructions.

**Characteristics on Usage**

Royalfil GS 703-C is a low hydrogen type "Metal Cored" arc welding wire. It gives good penetration, high resistance to porosity with controlled hydrogen. Intended for both semi automatic, automatic single & multiple welding with 80%Ar + 20% Co2 shielding. Characterized by a spray arc, excellent bead wash characteristics and no slag covering. Elimination of slag removal is especially beneficial in hard to reach areas.

**Welding Positions**

1G 2F

**Recommended Stick Out**

15-20 mm

**Shielding Gas**

80 % Ar + 20 % CO2 shielding  
Gas Flow : 20-25 Lit/Min

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %	Cu %
Typical Values	0.045	1.50	0.55	0.010	0.016	0.10	0.40	0.30
Specific reqd.	0.12 Max	1.75 Max	0.90 Max	0.030 Max	0.030 Max	0.20 Max	0.5 Max	0.50 Max

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	CVN IMPACT AT - 20°C ( J )
Typical Values	585	490	26	75
Specific reqd.	480 Min	400 Min	22 Min	27 Min

**Welding Parameters (DC + VE)**

Diameter (mm)	Flat & Horizontal	
	(A)	(V)
1.20	160-210	28-34
1.60	180-250	28-34

**Packing**

15 kgs.vaccum packed plastic spool.