

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 706-C is a 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	0.5 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
Typical Values	585	490	26	60
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.