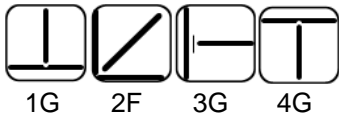


Applications

Royalfil-GS-106 is suitable for the welding of difficult to weld steel like spring steels. Cast steels, tool steels, high speed steels, case hardening steels, manganese steels, steels of unknown chemical composition, dissimilar joints between stainless steel & high carbon steel, to weld cast alloys of similar composition. Also used for laying buffer before hardfacing .

Characteristics on Usage

Royalfil GS-106 a stainless steel flux core welding wire for all position welding with CO₂ gas shielding. It gives the 30% Cr and 9% Ni weld deposit which has excellent oxidation resistance. The weld metal has a two phase structure with substantial amount of ferrite in austenitic matrix. Deposited weld metal is highly resistance to cracks & fissures. Weld metal is of radiographic quality.

Welding Positions

1G 2F 3G 4G

Recommended Stick Out

15-20mm

Shielding GasCarbon Dioxide (CO₂) shielding
Gas Flow :15-20 Lit / Min**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cu %
Typical Values	0.030	1.60	0.65	0.008	0.030	28.5	9.0	0.070	0.090
Spec. Reqd.	0.15 Max	0.5-2.5	1.0 Max	0.030 Max	0.040 Max	28.0-32.0	8.0-10.5	0.75 Max	0.75 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	750	24
Spec. Reqd.	660 Min	22 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	160-210	26-30	120-210	22-26	160-210	26-30
1.60	190-250	26-30	160-250	21-27	190-250	26-30

Packing

12.5 kgs. vaccum packed plastic spool.