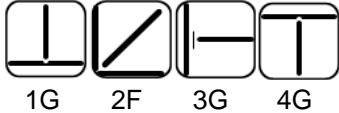


Applications

Royalfil GS-1C is used for welding of 18%Cr, 9% Nickel Steel for joining Austenitic Steels such as 304, 304 L, 321, CF-8, CF-3

Characteristics on Usage

Royalfil GS-1C is an extra low carbon Lime Titania all position 19% Cr-10 % Ni stainless steel gas shield flux cored wire. The weld deposit is highly resistance intergranular corrosion, cracking, oxidation and scaling. It gives uniform and fine rippled bead characterized by excellent all around performance and mechanical properties. Weld metal is of radiographic quality with easy slag removal and low spatters

Welding Positions

1G 2F 3G 4G

Recommended Stick Out

15-20mm.

Shielding Gas

Carbon 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	1.50	0.60	0.010	0.030	19.80	9.50	0.050	0.10
Spec. Reqd.	0.040	0.5-2.50	0.010 Max	0.030 Max	0.040 Max	18-21 Max	9.0-11.0	0.50 Max	0.50 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	580	40
Spec. Reqd.	520 min	35 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

Approvals

RDSO - IRS M 46 CLASS VI ,DNV

Packing

12.5 kgs. vaccum packed plastic spool.