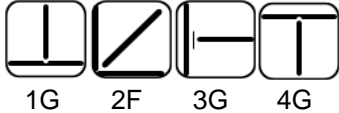


Applications

It is used for welding of 18% Cr, 12% Ni & 2.50% Mo steel also use for welding of AISE 316L & 317L type of stainless steel in chemical plant, paint, pulp paper & textile industries,CF-8M,CF-3M

Characteristics on Usage

Royalfil GS – 2C is an extra low carbon rutile coated all position stainless steel flux core welding wire with CO₂ gas shielding. It gives the weld deposit of 18% Cr, 12% Ni & 2% Mo etc. It runs smoothly & gives uniform weld metal deposit with easily slag removal. The weld metal is highly resistance to intergranular corrosion . 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%	P%	Cr %	Ni %	Mo %	Cu %
Typical Values	0.030	1.50	0.70	0.030	18.50	12.05	2.50	0.10
Spec. Reqd.	0.040 Max	0.50-2.50	1.0 Max	0.040 Max	17-20	11-14	2.0-3.0	0.75 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	580	38
Spec. Reqd.	485 Min	30 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.