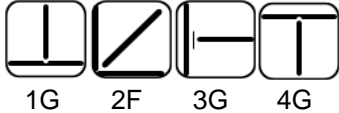


Applications

Royalfil-GS-D2H is suitable for the welding of dissimilar metals such as stainless steel and carbon steel or stainless steel and low alloy steel. Ferrite content is about 6 -7 FN which makes this welding wire suitable for welding of 23 Cr – 12.5 Ni wrought & cast steels designed for corrosion and oxidation resistance.

Characteristics on Usage

Royalfil GS-D2H is a stainless steel flux core welding wire for all position welding with co2 shielding gases. It gives the 23% Cr and 12% Ni weld deposit with excellent all around performance and resistance to chemical corrosion. Carbon restriction helps to provide higher tensile strength & creep strength at elevated temp.

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	0.055	1.60	0.65	0.010	0.030	23.20	12.50	0.050	0.10
Spec. Reqd.	0.04-0.10	0.5-2.50	1.00 Max	0.03 Max	0.040 Max	22.0-25.0	12.0-14.0	0.75 Max	0.75 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	610	35
Spec. Reqd.	550 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.