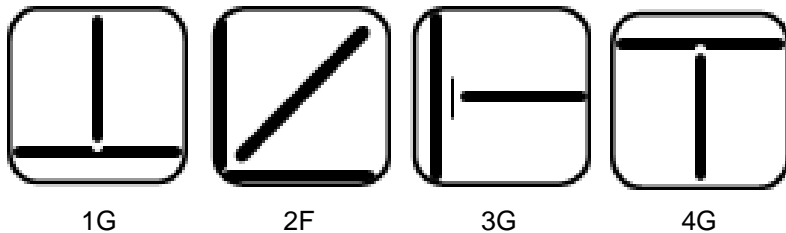


Applications

Used for fabrication in chemical plant machinery structures & steel fabrication in ship building, heavy bridges, towers. earth moving equipments etc.

Characteristics on Usage

RoyalFil Dual T9R is all position flux cored wire having ability to produce higher deposition rates using CO₂ or Ar+CO₂ shielding. Weld metal is consistently free of inclusions, porosity & is of radiographic quality. The wire is formulated to produce less fumes & minimum spatters. Slag coverage is complete & gets removed very easily. Designed for single pass & multiple pass welding of low & medium carbon steels with improved impact properties. Meets the new AWS A 5.20 'D' designation requirements.

Welding Positions

1G

2F

3G

4G

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values *	0.045	1.25	0.40	0.010	0.018	0.40
Spec. Req'd. *	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max
Typical Values **	0.055	1.55	0.50	0.010	0.018	0.40
Spec. Req'd.**	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max

Mechanical Properties Of Weld Metal

Typical Values * Under CO₂ Shield; ** 80% Argon + 20% CO₂ Shield

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
Typical Values*	580	490	26	60
Spec. Req'd.*	490- 670	390 Min	22 Min	27 Min
Typical Values **	600	515	26	80
Spec. Req'd.**	490-670	390 Min	22 Min	27 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (A)	Vertical - Up (V)	Overhead (A)	Overhead (V)
1.20	180-250	26-30	120-210	22-26	150-200	26-30
1.60	210-280	26-30	160-250	22-27	190-240	26-30

Packing

15 kgs. vacuum packed plastic spool.