

ROYALFIL GS 1 B (E347T1-1)

AWS A / SFA 5.22 E347T1 - 1

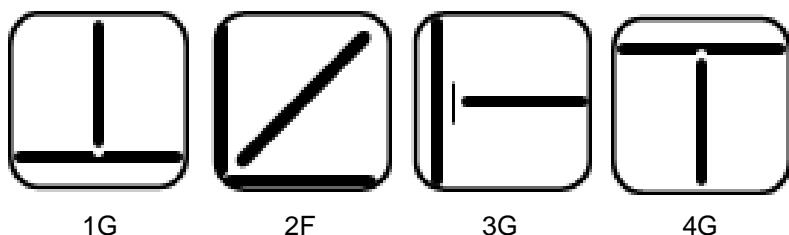
Applications

Used to weld type 321, 347 & 348 stainless steel for joining & cladding application on Niobium and Titanium stabilized stainless steel.

Characteristics on Usage

A lime titania all position stainless steel flux cored wire gives 19.% Cr, 10% Ni, & 0.35% Niobium weld deposit with Co₂ gas shield. The weld metal is excellent resistance to intergranular corrosion, stable arc with improved weld pool control for weldability, bright finely rippled weld bead, reduces chromium carbide precipitation etc. Weld metal is of radiographic quality with easy slag removal and low spatters.

Welding Positions



Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %
Typical Values	0.030	1.50	0.65	0.010	0.030	19.50	10.00
Spec.Reqd.	0.080	0.5-2.50	1.0 Max	0.030	0.040 Max	18.0-21.0	9.0-11.0

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	590	35
Spec. Reqd.	520 Min	30 Min

Welding Parameters (DC + VE)

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

Packing

12.5 kgs. vacuum packed plastic spool.