

ROYALFIL GS 1 CH (E308HT1-1)

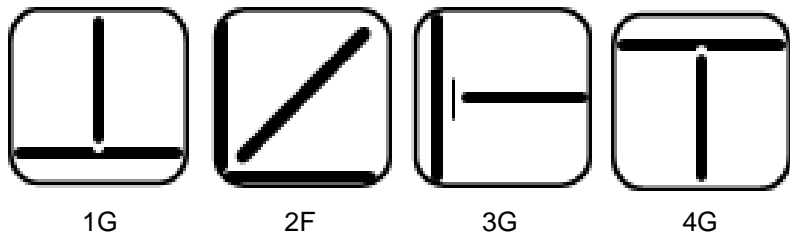
AWS A / SFA 5.22 E308 HT1-1

Applications

Royalfil GS-1CH is used for welding of 304H, 308H type base metal.

Characteristics on Usage

Royalfil GS-1CH is a all position 19Cr-10 Ni stainless steel gas shield flux core wire. It gives uniform and fine rippled bead characterized by excellent all around performance and mechanical properties. Carbon percentage is in the range of 0.04 – 0.08 %, which provides higher tensile and creep strength at elevated temperatures. Weld metal is of radiographic quality with easy slag removal & low spatters.

Welding Positions

1G

2F

3G

4G

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %
Typical Values	0.055	1.50	0.60	0.010	0.030	19.80	9.7
Spec. Reqd.	0.04 –0.08	0.5-2.50	1.0 Max	0.03 Max	0.04 Max	18.0-21.0	9.0-1

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	605	39
Spec. Reqd.	550 Min	35 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.