

ROYALFIL GS 12M (E71T-1M)

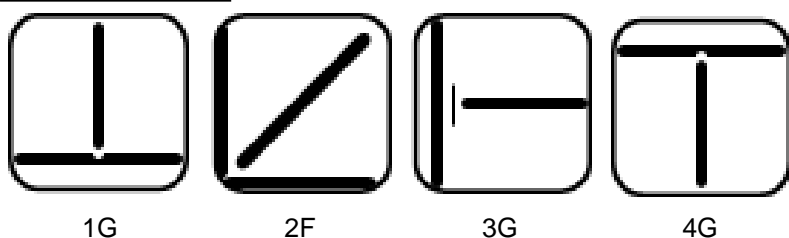
AWS A / SFA 5.20 E71T-1M

Applications

Royalfil GS-12M is designed for single and multiple pass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM A-36 /A-36M, A 283 / A 283M, A 414 / A414M, Fabrication in chemical plant machinery structures & Steel Sheets in ship building, auto industries, heavy bridges, towers, electrical appliance industries, earth moving equipments etc.

Characteristics on Usage

Royalfil GS-12M is an all position rutile type flux cored wire designed for optimum performance when using 80% Argon – 20% CO₂ shielding gas. Weld Metal is consistently free of inclusions, porosity & is of radiographic quality. Slay coverage is complete & gets removed very easily. This wire characterized by a spray transfer, low spatter loss, less fumes & having ability produce higher deposition rates. It is more resistant to burn-through also.

Welding Positions**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%
Typical Values	0.055	1.30	0.45	0.010	0.018
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.030 Max	0.030 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 20°C (J)
Typical Values	590	500	26	70
Spec. Reqd.	490-670	390 Min	22 Min	27 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	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.