

ROYALFIL GS 15 RB (E71T-5 C)

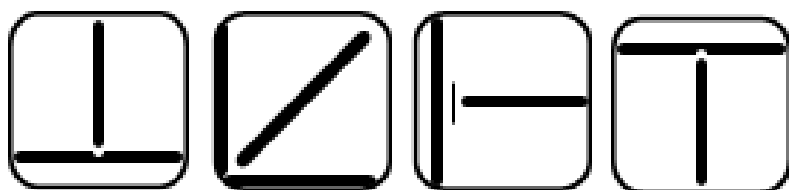
AWS A / SFA 5.20 E71T - 5C

Applications

Royalfil GS-15RB is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-525-70, and C grades of SA-285, IS: 2002-2A & 2B IS2062, IS226 & DIN 17155 HIV e.g. Construction of bridges, Pressure vessel & Offshore structures.

Characteristics on Usage

Royalfil GS-15RB is an all position basic type flux cored wire-having stable and smooth arc with good slag detachability using CO₂ shield. The slag coverage is complete and easy to remove. Weld metal is consistently free of inclusions and porosity for radiography soundness. This wire is formulated to have high resistance to cracking with fewer fumes & minimal spatter.

Welding Positions

1G

2F

3G

4G

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values	0.050	1.25	0.45	0.010	0.018	0.40
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
Typical Values	550	470	26	60
Spec. Reqd.	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

Approvals

IBR

Packing

15 kgs. vacuum packed plastic spool.