

**ROYALFIL GS 15B-A1 (E71T5-A1 C)**

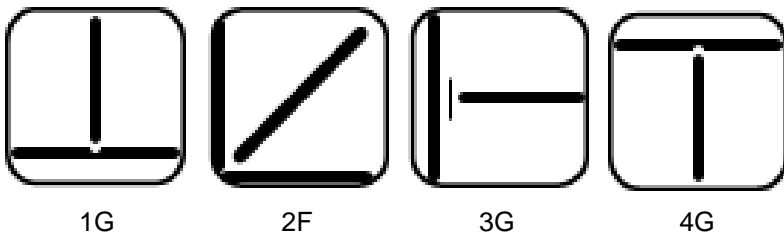
AWS A / SFA 5.29 E71T5 - A1 C

**Applications**

Suitable for single & multiple pass welding using DCEP polarity. It is used for welding of similar composition of MO steels & other creep resistant steels with Co<sub>2</sub> shielding .Commonly used in steam power plants, marine, chemical plants & refineries.

**Characteristics on Usage**

RoyalFil GS 15B - A1 is Basic type low alloy steel all position welding wire with less spatter, smooth & stable arc, with good penetration & easily removable thin slag. Weld metal is of radiographic quality with low temp. toughness as down to -30°C.

**Welding Positions**

1G

2F

3G

4G

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Mo %
Typical Values	0.050	1.00	0.45	0.010	0.018	0.50
Spec. Reqd.	0.12 Max	1.25 Max	0.80 Max	0.030 Max	0.030 Max	0.4 –0.65

**Mechanical Properties Of Weld Metal**

(After PWHT at 620°C for 1 Hr)

Property	U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT ( CVN ) AT - 30° C ( J )
Typical Values	550	460	25	50
Spec. Reqd.	490 - 620	400 Min	20 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	150-210	22-26	150-200	26-30
1.60	210-280	26-30	180-250	21-27	190-240	26-30

**Packing**

15 kgs. vacuum packed plastic spool.