

ROYALFIL GS 18 R (E81T1-W2 C)

AWS A / SFA 5.29 E81T1-W2 C

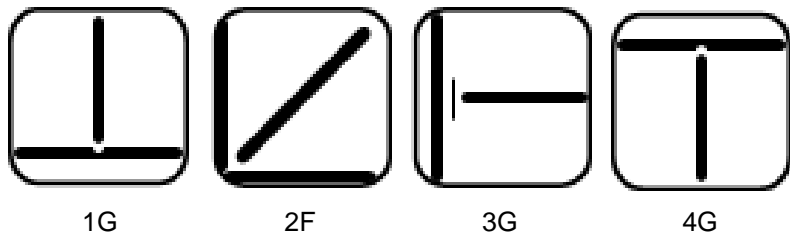
Applications

Royalfil-18R is designed for welding atmospheric corrosion resistant steel as Resco, corton & ITACOR. Suitable for joining weathering grade steels conforming to ASTM SA-588, SA-242 etc.

Characteristics on Usage

Royalfil GS-18R is Rutile base all position flux cored wire for welding of low alloy. This wire is having stable and smooth arc with good slag detachability & excellent bead appearance with CO2 shield. This wire is designed for welding CORTON grade weather resistance steels.

Welding Positions



Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni
Typical Values	0.05	0.97	0.45	0.01	0.018	0.62	0.6
Spec. Reqd.	0.12 Max	0.50 -1.30	0.35 -0.80	0.03 Max	0.03 Max	0.45- 0.70	0.40-

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	600	510	25	50
Spec. Reqd.	550-690	470 Min	19 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

RDSO-IRS CLASS IV

Packing

15 kgs. Vacuum packed plastic spool.