

ROYALFIL GS 2 C (E316LT1-1)

AWS A / SFA 5.22 E 316LT1-1

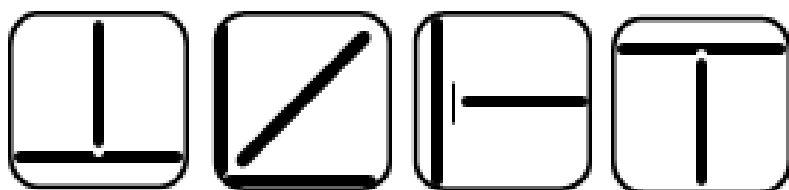
Applications

It is used for welding of 18% Cr, 12% Ni & 2.50% Mo steel also use for welding of AISE 316L & 317L type of stainless steel in chemical plant, paint, pulp paper & textile industries,CF-8M,CF-3M

Characteristics on Usage

Royalfil GS – 2C is an extra low carbon rutile coated all position stainless steel flux core welding wire with CO2 gas shielding. It gives the weld deposit of 18% Cr, 12% Ni & 2% Mo etc. It runs smoothly & gives uniform weld metal deposit with easily slag removal. The weld metal is highly resistance to intergranular corrosion . Weld metal is of radiographic quality with easy slag removal and low spatters.

Welding Positions



1G

2F

3G

4G

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %
Typical Values	0.030	1.50	0.70	0.010	0.030	18.50	12.00
Spec. Reqd.	0.040 Max	0.50-2.50	1.0 Max	0.030 Max	0.040 Max	17-20	11-14

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	580	38
Spec. Reqd.	485 Min	30 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.