

ROYALFIL GS 2CH (E316HT1-1)

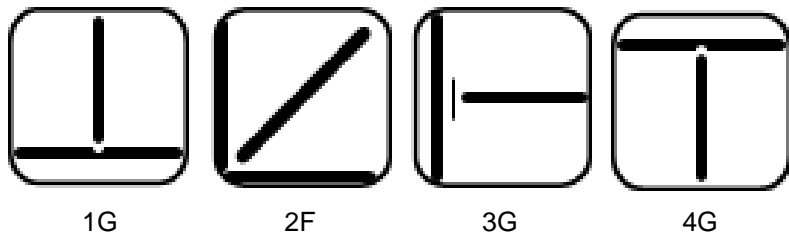
AWS A / SFA 5.22 E316HT1-1

Applications

RoyalFil GS 2CH is used for welding of 316H type base metal.

Characteristics on Usage

RoyalFil GS 2CH is a all position 18% Cr, 12% Ni, 2% Mo stainless steel gas shield flux cored wire. It gives uniform and fine rippled bead characterized by excellent all around performance and mechanical properties. Carbon percentage is in the range of 0.04-0.08 %, which provides higher tensile and creep strength at elevated temperatures. Weld metal is of radiographic quality with easy slag removal & low spatters.

Welding Positions**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %
Typical Values	0.055	1.50	0.60	0.010	0.030	18.50	12.00
Spec. Reqd.	0.04-0.08	0.50-2.50	1 Max	0.03 Max	0.04 Max	17-20	11-14

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical values	590	37
Spec. Reqd.	520 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.