

**ROYALFIL GS 31 RB (E70T-5 C)**

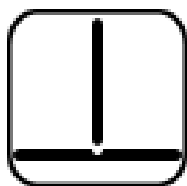
AWS A / SFA 5.20 E70T-5 C

**Applications**

Royalfil GS-31RB is designed for single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM Grade C,D,E OF SA-414 /SA-414M, (P.No.1) Typical application includes steel plant equipments, heavy machinery etc.

**Characteristics on Usage**

Royalfil GS-31RB is basic type flux cored wire for flat & horizontal welding with CO<sub>2</sub> shielding. The slag coverage is complete and easy to remove. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce fewer fumes, minimal spatter.

**Welding Positions**

1G



2F

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values	0.05	1.41	0.40	0.010	0.018	0.30
Spec. Req'd.	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.	Y.S.	ELONGATION	IMPACT ( CVN )
	(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT - 30° C ( J )
Typical Values	550	470	26	60
Spec. Req'd.	480 Min	400 Min	22 Min	27 Min

**Welding Parameters (DC + VE)**

Diameter	Flat & Horizontal	Flat & Horizontal
(mm)	(A)	(V)
1.20	180-250	26-30
1.60	210-280	26-30

**Packing**

15 kgs. vacuum packed plastic spool.