

ROYALFIL GS 36 B (E80T5-K1 C)

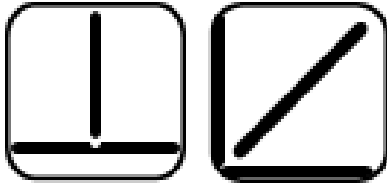
AWS A / SFA 5.29 E80 T5- K1 C

Applications

This flux cored wire primarily intended for as welded applications. It can also be used long for long term stress relieved applications for welding of low alloy high strength steels in particular 1% nickel steels. Recommended for pressure vessels or fabrication of thicker section which require subzero impact properties.

Characteristics on Usage

It is low hydrogen type flux cored wire with highly basic slag having stable & smooth arc, good slag detachability. Weld metal is of radiographic quality. It is used for flat & horizontal position welding with CO₂ shielding.

Welding Positions

1G

2F

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Ni %	Mo
Typical Values	0.045	1.00	0.50	0.010	0.015	1.00	0.4
Spec. reqd.	0.15 Max	0.80-1.40	0.80 Max	0.030 Max	0.030 Max	0.80-1.10	0.20-

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT -40 °C (J)
Typical Values	620	530	23	50
Spec. reqd.	550-690	470 Min	19 Min	27 Min

Welding Parameters (DC + VE)

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

Packing

15 kgs. vacuum packed plastic spool.