

ROYALFIL GS 36 R (E80T1-K2 C)

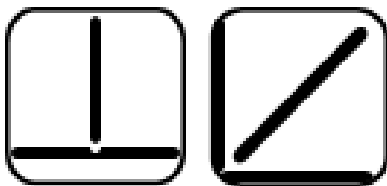
AWS A/ SFA 5.29 E80T1-K2 C

Applications

Royalfil-GS-36R is welding wire for welding of high tensile steel used in machinery, structures bridges etc. Steels welded are Hy80, Hy100. ASTM A 710, ASTM A 514 and similar high strength steels.

Characteristics on Usage

Royalfil GS-36R is a low alloy rutile base flux cored wire depositing approximately 1.0-2.0% Ni & 0.20% Mo weld metal. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity with very good mechanical strength. It is used for flat & horizontal welding with CO₂ shield. Weld metal is of radiographic quality.

Welding Positions

1G

2F

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %
Typical Values	0.05	1.20	0.40	0.010	0.018	0.10	1.5
Spec. Req'd.	0.15 Max	0.50- 1.75	0.80 Max	0.03 Max	0.03 Max	0.15 Max	1.00 -

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	620	530	24	60
Spec. Req'd.	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.