

**ROYALFIL GS 43 R (E110T1-K4 C)**

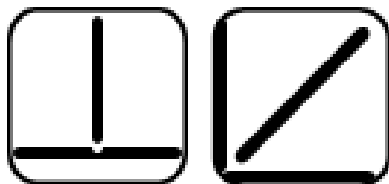
AWS A /SFA 5.29 E110T1- K4 C

**Applications**

It is primarily intended for as welded applications for welding wire low alloy high strength steels. Addition of approximately 0.50Cr provides higher strength for many applications needing in excess of 830 N/ mm<sup>2</sup> tensile strength such as "armour" plate. Typical applications include welding of Hy 100 and ASTM A 514 steels.

**Characteristics on Usage**

RoyalFil GS 43R is Rutile base low hydrogen type flux cored wire designed for single and multiple pass welding in flat and horizontal positions with CO<sub>2</sub> shielding. 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	0.050	1.40	0.50	0.010	0.015	0.50	2.0
Spec. reqd.	0.15 Max	1.20-2.25	0.80 Max	0.030 Max	0.030 Max	0.20-0.65	1.75-

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	CVN IMPACT AT - 20°C ( J )
Typical Values	830	740	20	60
Spec. reqd.	760-900	680 Min	15 Min	27Min

**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.