

ROYALFIL GS 706 C (E70C-6M)

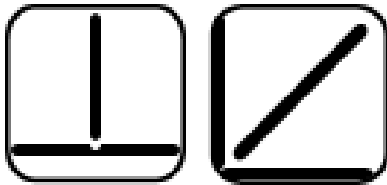
AWS-SFA A 5.18 E70C- 6M

Applications

It is used for welding of medium & high tensile steel with mixed gas 80%Ar + 20% Co₂ shielding in ship building, machineries, structural fabrication and bridge constructions.

Characteristics on Usage

Royalfil GS 706-C is a metal Cored arc welding wire. It gives good penetration high resistance to porosity with controlled hydrogen. Intended for both semi automatic, automatic single & multiple welding with 80%Ar + 20% Co₂ shielding. Characterized by a spray arc, excellent bead wash characteristics and no slag covering. Elimination of slag removal is especially beneficial in hard to reach areas.

Welding Positions

1G

2F

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %
Typical Values	0.045	1.50	0.55	0.010	0.016	0.10	0.4
Specific reqd.	0.12 Max	1.75 Max	0.90 Max	0.030 Max	0.030 Max	0.20 Max	0.5 M

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	585	490	26	60
Specific reqd.	480 Min	400 Min	22 Min	27 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	180-250	28-34
1.60	200-300	28-34

Packing

15 kgs.vacuum packed plastic spool.