

ROYALFIL GS 81 B (E 81T1-G C)

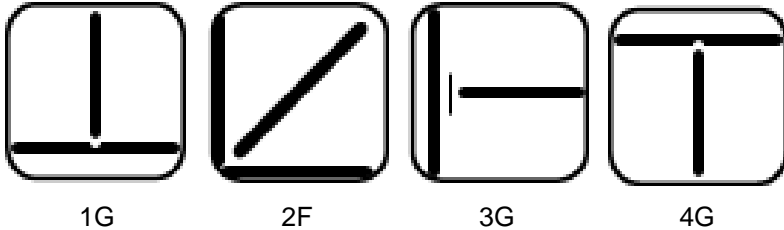
AWS A / SFA 5.29 E 81T1- G C

Applications

RoyalFil GS-81B is designed for all position single and multipass welding of ship-building steels etc.

Characteristics on Usage

RoyalFil GS-81B is a semi-automatic type gas shielded flux-cored wire, whereby CO₂ shield is applicable. The weld metal is of radiographic quality with excellent impact strength at sub-zero temperatures up to minus 20°C. The slag coverage is complete and designed for easy removal. The wire is specially designed for welding of ship building steels, etc

Welding Positions**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values	0.06	1.50	0.70	0.010	0.015	0.75
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Min

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 20°C (J)
Typical Values	635	560	25	60
Spec.Reqd.	550-690	470 Min	19 Min	27 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal	Flat & Horizontal	Vertical - Up	Vertical - Up	Overhead	Overhead
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	180-250	26-30	120-210	22-26	150-200	26-30
1.60	210-280	26-30	160-250	22-27	190-240	26-30

Approvals

IRS

Packing

15 kgs. vacuum packed plastic spool.