

ROYALFIL GS 91 R (E91T1-G C)

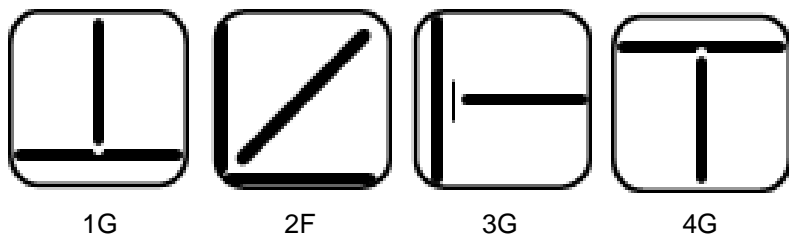
AWS A / SFA 5.29 E91T1- G C

Applications

Royalfil-GS-91R fcw wire is used for high tensile, fine grain structural steel, creep resistant fine grain structural steels, heat treated fine grain structural steel.

Characteristics on Usage

Royalfil GS-91 R is Rutile base gas shielded flux cored wire welding for all position welding with Co₂ shielding depositing radiographic quality metal. Arc is smooth & stable with low spatter and good bead appearance.Slag.

Welding Positions**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Ni %	Mo
Typical Values	0.065	1.40	0.35	0.008	0.018	1.20	0.4
Spec. Req'd.	0.05 - 0.08	1.20-1.60	0.25-0.40	0.03 Max	0.03 Max	1.0-1.40	0.3-0.4

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	670	590	22	80
Spec. Req'd.	620 Min.	540 Min.	17 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

Packing

15 kgs. vacuum packed plastic spool.