

ROYALFIL GS 31 RB (E70T-5 C)

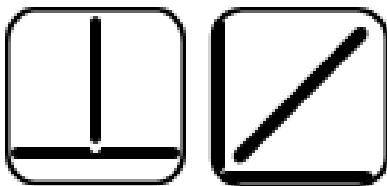
AWS A / SFA 5.20 E70T-5 C

Applications

Royalfil GS-31RB is designed for single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM Grade C,D,E OF SA-414 /SA-414M, (P.No.1) Typical application includes steel plant equipments, heavy machinery etc.

Characteristics on Usage

Royalfil GS-31RB is basic type flux cored wire for flat & horizontal welding with CO₂ shielding. The slag coverage is complete and easy to remove. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce fewer fumes, minimal spatter.

Welding Positions

1G

2F

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values	0.05	1.41	0.40	0.010	0.018	0.30
Spec. Req'd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max

Mechanical Properties Of Weld Metal

Property	U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
	(N/mm ²)	(N/mm ²)	(L = 4d) %	AT - 30° C (J)
Typical Values	550	470	26	60
Spec. Req'd.	480 Min	400 Min	22 Min	27 Min

Welding Parameters (DC + VE)

Diameter	Flat & Horizontal	Flat & Horizontal
(mm)	(A)	(V)
1.20	180-250	26-30
1.60	210-280	26-30

Packing

15 kgs. vacuum packed plastic spool.