

**ROYALFIL GS 36 B (E80T5-K1 C)**

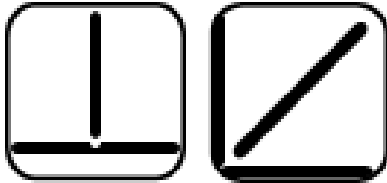
AWS A / SFA 5.29 E80 T5- K1 C

**Applications**

This flux cored wire primarily intended for as welded applications. It can also be used long for long term stress relieved applications for welding of low alloy high strength steels in particular 1% nickel steels. Recommended for pressure vessels or fabrication of thicker section which require subzero impact properties.

**Characteristics on Usage**

It is low hydrogen type flux cored wire with highly basic slag having stable & smooth arc, good slag detachability. Weld metal is of radiographic quality. It is used for flat & horizontal position welding with CO<sub>2</sub> shielding.

**Welding Positions**

1G

2F

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Ni %	Mo
Typical Values	0.045	1.00	0.50	0.010	0.015	1.00	0.4
Spec. reqd.	0.15 Max	0.80-1.40	0.80 Max	0.030 Max	0.030 Max	0.80-1.10	0.20-

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT (CVN) AT -40 °C ( J )
Typical Values	620	530	23	50
Spec. reqd.	550-690	470 Min	19 Min	27 Min

**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.