ROYALFIL GS 45 R (E120T1-G C)

AWS A / SFA 5.29 E120T1- G C

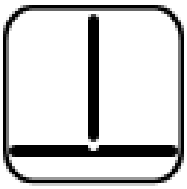
Applications

For welding of high strength fine grain structured steel having yield strength around 750 N/mm2

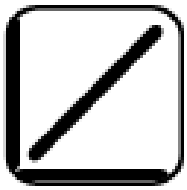
Characteristics on Usage

RoyalFil GS - 45R is Rutile base flux cored wire for flat & horizontal position welding. It gives stable arc easily detachable slag, uniform bead & less spatters with Co2 shield. Weld metal is of radiographic quality.

Welding Positions



1G



2F

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni
Typical Values	0.050	1.70	0.45	0.010	0.015	1.00	2.2
Spec. Reqd.	0.12 Max	1.50-1.80	0.80 Max	0.030 Max	0.030 max	0.80-1.30	2.00-

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm²)	Y.S. (N/mm²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
Typical Values	900	810	18	50
Spec.Reqd.	830 Min	745 Min	14 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.