

ROYALFIL GS 80 RB (E80T5-B2 C)

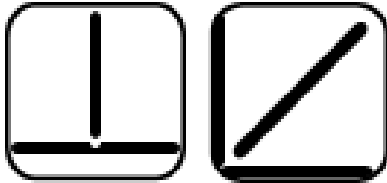
AWS A / SFA 5.29 E80 T5 - B2 C

Applications

Since all Cr-Mo electrodes produce weld metal which will harden in still air, both preheat & post weld heat treatment are required for most applications. Specially design for Cr-Mo Steels with high temp & pressure service condition in steam pipes of boilers.

Characteristics on Usage

RoyalFil GS 80 RB 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 CO₂ shielding.

Welding Positions

1G

2F

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Mo %
Typical Values	0.060	0.70	0.40	0.010	0.015	1.25	0.5
Spec. reqd.	0.05 –0.12	1.25 Max	0.80 Max	0.030 Max	0.030 Max	1.00-1.50	0.40-

Mechanical Properties Of Weld Metal

(After PWHT at 690 ± 15°C for 1 Hr)

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	600	545	24.50
Spec. reqd.	550-690	470 Min	19 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.