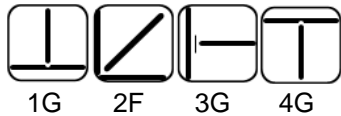


**Applications**

Royal Super -71 is Rutile type flux cored wire designed for all position single and mulipass welding of low and medium carbon steels.Used for welding in bridges,structural fabrication,vehicles, peb etc.

**Characteristics on Usage**

Royal Super -71 is designed for optimum performance when using CO2 shielding. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. The slag coverage is complete and designed for easy removal. 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****Recommended Stick Out**

15 - 20mm

**Shielding Gas**

Carbon Dioxide (CO2) shielding  
Gas Flow :20-25 Lit / Min

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%
Typical Values	0.045	1.20	0.35	0.010	0.020
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	CVN IMPACT AT - 20°C ( J )
Typical Values	575	480	26.5	80
Spec. Reqd.	490-670	390 Min	22 Min	27 Min

**Welding Parameters (DC + VE)**

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	180-250	26-30	120-210	22-26	150-200	26-30

**Packing**

15 kgs. vaccum packed plastic spool.