

ROYALFIL GS 1 C (E308LT1-1)

AWS A / SFA 5.22 E308 LT1-1 EN ISO 17633 A T199LRC1

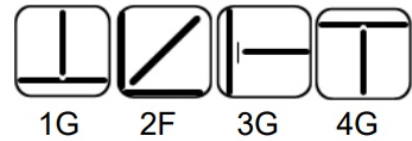
Applications

Royalfil GS-1C is used for welding of 18%Cr, 9% Nickel Steel for joining Austenitic Steels such as 304, 304 L, 321, CF-8, CF-3

Characteristics on Usage

Royalfil GS-1C is an extra low carbon Lime Titania all position 19% Cr-10 % Ni stainless steel gas shield flux cored wire. The weld deposit is highly resistance intergranular corrosion, cracking, oxidation and scaling. It gives uniform and fine rippled bead characterized by excellent all around performance and mechanical properties. Weld metal is of radiographic quality with easy slag removal and low spatters

Welding Positions



Recommended Stick Out

15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) Shielding
Gas Flow : 15-20 Lit / Min

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%
0.040	0.5-2.50	1.0 Max	0.03 Max	0.04 Max	18.0-21.0
NI%	Mo%	Cu%			
9.0-11.0	0.75 Max	0.75 Max			

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)
550-580 Min	35-40 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (V)	Vertical - Up (V)	Overhead (V)	Overhead (V)
1.20	180-250	26-30	120-210	22-26	150-200	26-30
1.60	210-280	26-30	160-250	22-27	190-240	26-30

Packing

15 kgs. Vacuum packed plastic spool