

ROYALFIL GS 1 CH (E308HT1-1)

AWS A / SFA 5.22 E308 HT1-1 EN ISO 17633 A T199NbRC1

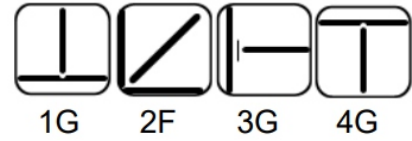
Applications

Royalfil GS-1CH is used for welding of 304H, 308H type base metal.

Characteristics on Usage

Royalfil GS-1CH is a all position 19Cr-10 Ni stainless steel gas shield flux core wire. It gives uniform and fine rippled bead characterized by excellent all around performance and mechanical properties. Carbon percentage is in the range of 0.04 – 0.08 %, which provides higher tensile and creep strength at elevated temperatures. Weld metal is of radiographic quality with easy slag removal & 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%
0.04 –0.08	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)
550-605 Min	35-39 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