ROYALFIL GS 100 D2 (E 100T5-D2C)

AWS A / SFA 5.29 E 100 T5-D2CEN ISO 18276 A T624MnMoBC3H5

FLUX CORED WIRE : LOW ALLOY STEEL

Applications

Royalfil GS- 100 D2 is designed for welding of high strength, low alloy pressure vessels steel is such as A302 Gr. B, HSLA steels and Manganese- Molybdenum castings, such as ASTM A 49, A 291 and A 735 etc. to meet low temperature toughness as well as down to – 40 Deg c.

Characteristics on Usage

Royalfil GS-100 D2 is low alloy basic flux cored wire depositing 2.0 % Mn, 0.4 % Mo weld metal with CO2 shielding. The weld deposit is of radiographic quality with very low diffusible hydrogen and stable and smooth arc with good slag detachability. However, the weld metal from these Mn-Mo steel electrodes is quite air-hardenable and usually requires preheat and PWHT.

Welding Positions

1G 2F

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%
0.15 Max	1.65-2.25	0.80 Max	0.030 Max	0.030 Max

Mo%
0.25-0.55

Mechanical Properties Of Weld Metal

U.T.S. (N/mm^2)	Y.S. (N/mm^2)	ELONGATION (L = 4d) %	MPACT(CVN) AT -30 °C (J)
690-830	610-660 Min	16-20 Min	27-60 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. Vaccum packed plastic spool