

ROYALFIL GS 11 R (E70T-1C)

AWS A / SFA 5.20 E70T-1C EN / ISO 17632 A T422RC3H5

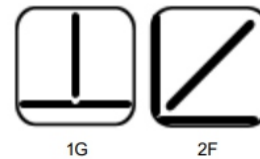
Applications

Royalfil GS-11R is for mass production in a wide range in mild and low alloy steels. Suitable for joining steels conforming to ASTM SA-36/SA-36M and A, B, C, D grades of SA-283 / SA-283M. Examples:- Fabrication in chemical plant machinery structures & Steel frames in ship building, heavy bridges & towers.

Characteristics on Usage

Royalfil GS-11R is Rutile flux cored wire designed for optimum performance in flat and horizontal positions when using CO₂ shielding. The slag coverage is complete and designed for easy removal with fewer fumes, minimal spatter in flat and horizontal positions. Weld metal is of radiographic quality.

Welding Positions



Recommended Stick Out
15-20mm

OutShielding Gas

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

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Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12Max	1.75Max	0.90Max	0.03Max	0.03Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 20°C (J)
575-670 Min	390-470 Min	22-26Min	27-60Min

Packing and Welding Current

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (A)
1.20	180-250	26-30
1.60	210-280	26-30

Packing

15 kgs. vaccum packed plastic spool.