

ROYALFIL GS 12 H4R (E71T-1C H4)

AWS A / SFA 5.20 E71T-1C H4 EN / ISO 17632 A T422RC1H5

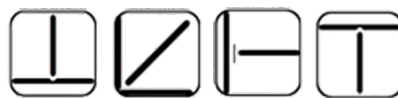
Applications

Royalfil GS -12H4R is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-36 /SA-36M and A,B,C,D grades of SA-283 / SA-283M & SA-414 / SA414M.(P.No.1) e.g. Fabrication in chemical plant machinery structures & Steel frames in ship building, heavy bridges & towers.

Characteristics on Usage

Royalfil GS-12H4R is low hydrogen all position Rutile flux cored wire designed for optimum performance when using CO₂ shield. 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

15-20 mm

Shielding Gas

Carbon Dioxide (CO₂)

Shielding Gas Flow :

20-25 Lit / Min

FLUX CORED WIRE : CARBON STEEL

Chemical Composition Of Weld Metal

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

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
490-670	390-470	22-26 Min	27-60 Min

Packing and Welding Current

SIZE (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (A)	Vertical - Up (V)	Overhead (A)	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.