

# ROYALFIL GS 12 R MOD-(BW) ( E71T-1C )

AWS A / SFA 5.20 E71T-1CEN / ISO 17632 A T422RC1H5

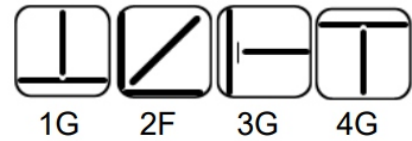
## Applications

Royalfil GS-12R MOD-(BW) 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 / SA-414M.(P.No.1) e.g. Fabrication in chemical plant machinery structures & Steel frames in ship building, heavy bridges & towers.

## Characteristics on Usage

Royalfil GS-12R MOD-(BW) is an all position Rutile flux cored wire designed for optimum performance when using CO<sub>2</sub> shielding. 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

15-20mm

## OutShielding Gas

Carbon Dioxide (CO<sub>2</sub>) Shielding  
Gas Flow : 15-20 Lit / Mi

FLUX CORED WIRE : CARBON STEEL

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12Max	1.75 Max	0.90 Max	0.030 Max	0.030 Max

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	MPACT(CVN) AT - 30°C ( J )
580-670 Min	390-485 Min	22-26.5 Min	27-80 Min

## Packing and Welding Current

SIZE ( mm )	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (A)	Vertical - Up (V)	Overhead (A)	Overhead (V)
1.00	140-220	24-28	100-190	22-26	140-190	25-28
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. vaccum packed plastic spool.