

ROYALFIL GS 12R LM (E71T-1C)

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

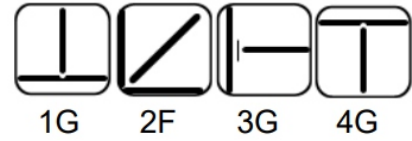
Applications

Royal fil GS-12R LM is low hydrogen & controlled manganese Rutile Type Flux Cored Wire 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-12RLM is designed for optimum performance when using CO₂ 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 (CO₂) Shielding
Gas Flow : 15-20 Lit / Mi

FLUX CORED WIRE : CARBON STEEL

Chemical Composition Of Weld Metal

| C% | Mn% | Si% | S% | P% |
|---------|----------|----------|-----------|-----------|
| 0.12Max | 1.15 Max | 0.90 Max | 0.030 Max | 0.030 Max |

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) |
|--------------------------------|------------------------------|----------------------------|-------------------------------|
| 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. vacuum packed plastic spool.