

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

AWS A / SFA 5.20 E71T-1MEN / ISO 17632 A T422RM1H5

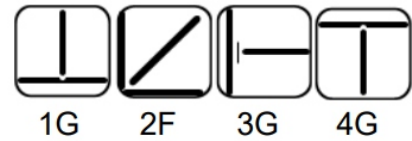
## Applications

Royalfil GS-12R MOD-M (BW) is all position Rutile type fluxcord wire for single and multipass welding of low and medium carbon steels. Used for welding in Shipbuilding, bridge construction, chemical plant machinery & other metal fabrication.

## Characteristics on Usage

Royalfil GS-12R MOD-M (BW) flux cored wire gives optimum performance with 80% Argon - 20% CO<sub>2</sub> shielding gas. Weld metal is consistently free of inclusions and porosity & is of radiographic quality. Slag coverage is complete & gets removed very easily. This wire characterized by a spray transfer, low spatter loss, less fumes & having ability produce higher deposition rates. It is more resistant to burn-through also.

## 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)
1.20	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.