

# ROYALFIL GS 15 RB (E71T-5 C)

AWS A / SFA 5.20 E71T - 5C EN / ISO 17632 A T423BC1H5

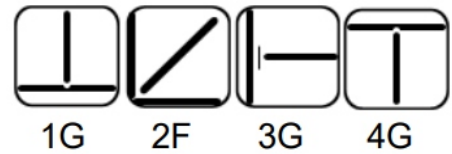
## Applications

Royalfil GS-15RB is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-525-70, and C grades of SA-285, IS: 2002-2A & 2B IS2062, IS226 & DIN 17155  
HIV e.g. Construction of bridges, Pressure vessel & Offshore structures

## Characteristics on Usage

Royalfil GS-15RB is an all position basic type flux cored wire- having stable and smooth arc with good slag detachability using CO<sub>2</sub> shield. The slag coverage is complete and easy to remove. Weld metal is consistently free of inclusions and porosity for radiography soundness. This wire is formulated to have high resistance to cracking with fewer fumes & minimal spatter.

## Welding Positions



**Recommended Stick Out**  
15-20mm

## OutShielding Gas

Carbon Dioxide (CO<sub>2</sub>) Shielding  
Gas Flow : 20-25 Lit / Min

FLUX CORED WIRE : CARBON STEEL

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	NI%
0.12Max	1.75Max	0.90Max	0.03Max	0.03Max	0.50Max

## 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 )
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.