

# ROYALFIL GS 15B-A1 (E71T5-A1 C)

AWS A / SFA 5.29 E71T5 - A1 C EN ISO 17632 A T383MoBC1H5

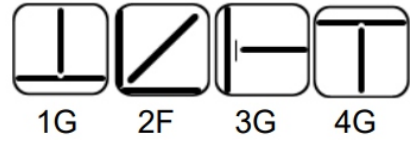
## Applications

Suitable for single & multiple pass welding using DCEP polarity. It is used for welding of similar composition of MO steels & other creep resistant steels with Co2 shielding. Commonly used in steam power plants, marine, chemical plants & refineries.

## Characteristics on Usage

RoyalFil GS 15B - A1 is Basic type low alloy steel all position welding wire with less spatter, smooth & stable arc, with good penetration & easily removable thin slag. Weld metal is of radiographic quality with low temp. toughness as down to -30°C.

## Welding Positions



## Recommended Stick Out

15-20mm

## OutShielding Gas

Carbon Dioxide (CO<sub>2</sub>) shielding  
Gas Flow: 15-20 Lit/Min.

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12 Max	1.25 Max	0.80 Max	0.030 Max	0.030 Max
Ni%				
0.4 -0.65				

## 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 )
490 - 620	400-460 Min	20-25 Min	27-50 Min

## Welding Parameters (DC + VE)

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