

ROYALFIL GS 18 R (E81T1-W2 C)

AWS A / SFA 5.29 E81T1-W2 C EN ISO 17632 A T4631NiRC1H5

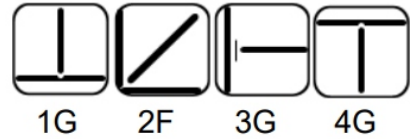
Applications

Royalfil-18R is designed for welding atmospheric corrosion resistant steel as Resco, corton & ITACOR. Suitable for joining weathering grade steels conforming to ASTM SA-588, SA-242 etc.

Characteristics on Usage

Royalfil GS-18R is Rutile base all position flux cored wire for welding of low alloy. This wire is having stable and smooth arc with good slag detachability & excellent bead appearance with CO₂ shield. This wire is designed for welding CORTON grade weather resistance steels.

Welding Positions



Recommended Stick Out

15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) Shielding
Gas Flow : 20-25 Lit / Min

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%
0.12Max	0.05-1.30	0.35-0.80	0.03 Max	0.03 Max	0.45-0.70
NI%	Cu%				
0.40-0.80	0.30-0.75				

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT - 0°C (J)
600-690 Min	470-510 Min	19-25 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