

# ROYALFIL GS 2CH (E316HT1-1)

AWS A / SFA 5.22 E316HT1-1EN ISO 17633 A T19123NbRC

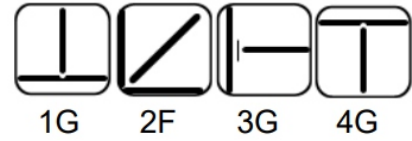
## Applications

For joining Manganese steel to dis-similar steels like stainless steels, carbon steel, alloy steel, difficult to weld steels & high alloys like Armour plates. Very good for repairing cracks in austenitic manganese steel casting, for laying buffer before hardfacing, surfacing manganese steel rails etc

## Characteristics on Usage

Royalfil GS 18.8.5 is a Gas shielded Stainless Steel flux cord wire for all position welding with CO<sub>2</sub> shielding gas depositing radiographic quality weld metal with 18%Cr, 8%Ni, 5% Mn composition. Weld metal has excellent crack resistance, corrosion resistance, easily machinable & has excellent heat resisting properties up to 9000C

## 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%	Cr%
0.20 Max	5.0-8.0	0.90 Max	0.030 Max	0.040 Max	17-20 Max
NI%	Mo%				
7.0-10.0	0.50 Max				

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )
560-670 Min	40-42 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	160-210	26-30	120-210	22-26	180-220	26-30
1.60	190-250	26-30	160-250	21-27	210-270	26-30

## Packing

15 kgs. Vacuum packed plastic spool