

ROYALFIL GS 19 R (E91T1-Ni2 C)

AWS A / SFA 5.29 E91T1-Ni2 C EN ISO 18276 A T5542NiMoRC1H5

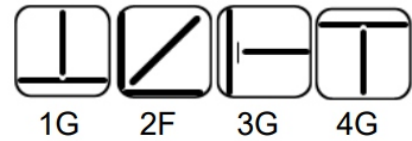
Applications

Royalfil-GS-19 R fcv wire has been designed to produce weld metal with increase strength (without being air hardenable) & with increase notch toughness at low temperature. This Nickel steel weld metal can be used without PWHT. Often used in structural applications where excellent toughness is required. For e.g. Construction machineries, Structural bridges & storage tanks. Ideal for welding quenched & tempered steels of HY 80 type.

Characteristics on Usage

Royalfil GS-19 R is Rutile base gas shielded flux cored wire welding for all position welding with Co2 shielding gas depositing radiographic quality metal. Arc is smooth & stable with low spatter and good bead appearance. Slag coverage s complete and easy removal

Welding Positions



Recommended Stick Out

15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) shielding
Gas Flow: 15-20 Lit/Min.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni%
0.12Max	1.50 Max	0.80 Max	0.030 Max	0.030 Max	1.75 -2.75

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT -40 °C (J)
620-760 Min	540-590 Min	17-21 Min	27-70 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