

# ROYALFIL GS 2 C (E316LT1-1)

AWS A / SFA 5.22 E 316LT1-1 EN ISO 17633 A T19123LRC1

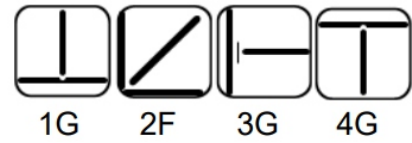
## Applications

It is used for welding of 18% Cr, 12% Ni & 2.50% Mo steel also use for welding of AISE 316L & 317L type of stainless steel in chemical plant, paint, pulp paper & textile industries,CF-8M,CF-3M

## Characteristics on Usage

Royalfil GS – 2C is an extra low carbon rutile coated all position stainless steel flux core welding wire with CO<sub>2</sub> gas shielding. It gives the weld deposit of 18% Cr, 12% Ni & 2% Mo etc. It runs smoothly & gives uniform weld metal deposit with easily slag removal. The weld metal is highly resistance to intergranular corrosion . Weld metal is of radiographic quality with easy slag removal and low spatters.

## 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%
0.040	0.5-2.50	1.0 Max	0.03 Max	0.04 Max	17-20
NI%	Mo%	Cu%			
11-14	2.0-3.0	0.75 Max			

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )
485-580 Min	30-38 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