

ROYALFIL GS 2CH (E316HT1-1)

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

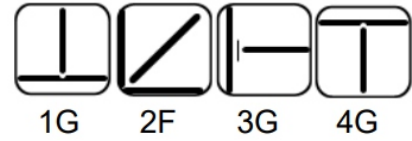
Applications

RoyalFil GS 2CH is used for welding of 316H type base metal.

Characteristics on Usage

Royalfil GS – 2C is an extra low carbon rutile coated all position stainless steel flux core welding wire with CO₂ 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 (CO₂) Shielding
Gas Flow : 15-20 Lit / Min

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%
0.04-0.08	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 ²)	Y.S. (N/mm ²)
520-590 Min	30-37 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