

ROYALFIL GS 31 RB (E70T-5 C)

AWS A / SFA 5.20 E70T-5 CEN / ISO 17632 A T423BC3H5

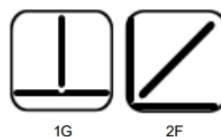
Applications

Royalfil GS-31RB is designed for single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM Grade C,D,E OF SA-414 /SA-414M, (P.No.1) Typical application includes steel plant equipments, heavy machinery etc.

Characteristics on Usage

Royalfil GS-31RB is basic type flux cored wire for flat & horizontal welding with CO₂ shielding. The slag coverage is complete and easy to remove. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce fewer fumes, minimal spatter.

Welding Positions



Recommended Stick Out

15-20 mm

Shielding Gas

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

FLUX CORED WIRE : CARBON STEEL

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni %
0.12Max	1.75Max	0.90Max	0.03Max	0.03Max	0.50Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
480-550 Min	400-470 Min	22-26Min	27-60 Min

Packing and Welding Current

SIZE (mm)	Flat & Horizontal (A)	Flat & Horizontal (A)
1.20	180-250	26-30
1.60	210-280	26-30

Packing

15 kgs. vacuum packed plastic spool.