

# ROYALFIL GS 36 B (E80T5-K1 C)

AWS A / SFA 5.29 E80 T5- K1 C EN ISO 17632 A T4641NiMoBC3H5

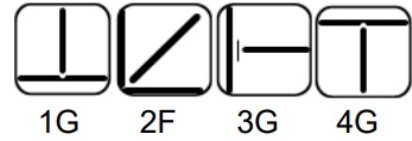
## Applications

This flux cored wire primarily intended for as welded applications. It can also be used long for long term stress relieved applications for welding of low alloy high strength steels in particular 1% nickel steels. Recommended for pressure vessels or fabrication of thicker section which require subzero impact properties.

## Characteristics on Usage

It is low hydrogen type flux cored wire with highly basic slag having stable & smooth arc, good slag detachability. Weld metal is of radiographic quality. It is used for flat & horizontal position welding with CO<sub>2</sub> shielding.

## 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%
0.15 Max	0.80-1.40	0.80 Max	0.030 Max	0.030 Max
Ni%	Mo%			
0.80-1.10	0.20-0.65			

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	MPACT(CVN) AT -30 °C ( J )
550-690	470-530 Min	19-23 Min	27-50 Min

## Welding Parameters (DC + VE)

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

## Packing

15 kgs. Vacuum packed plastic spool