

ROYALFIL GS 36 R (E80T1-K2 C)

AWS A/ SFA 5.29 E80T1-K2 C EN ISO 17632 A T4631.5NiRC3H5

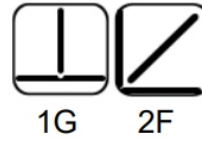
Applications

Royalfil-GS-36R is welding wire for welding of high tensile steel used in machinery, structures bridges etc. Steels welded are Hy80, Hy100. ASTM A 710, ASTM A 514 and similar high strength steels.

Characteristics on Usage

Royalfil GS-36R is a low alloy rutile base flux cored wire depositing approximately 1.0-2.0% Ni & 0.20% Mo weld metal. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity with very good mechanical strength. It is used for flat & horizontal welding with CO2 shield. Weld metal is of radiographic quality

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%
0.15 Max	0.50- 1.75	0.80 Max	0.030 Max	0.030 Max
Cr%	Ni%	Mo%		
0.15 Max.	1.00 - 2.00	0.35 Max		

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT -30 °C (J)
550-690	470-530 Min	19-24 Min	27-60 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