

ROYALFIL GS 41 B (E90T5-K2 C)

AWS A / SFA 5.29 E90T5-K2 CEN ISO 18276 A T555Mn1.5NiBC3H

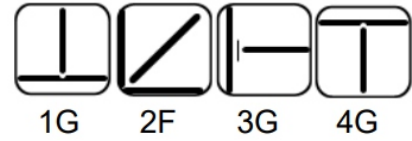
Applications

Royalfil GS-41B is suitable for welding of many HSLA steels like HY-80, Naxtra 56, 63, LA60 etc. Suitable for joining steels conforming to ASTM Grade 60, Grade 65 steel of SA-515/ SA-515M Grade 55, Grade 60, Grade 65 steels of SA516/SA-516M, all thickness range of SA-455/SA-455M etc.

Characteristics on Usage

Royalfil GS-41B is basic flux cored wire having stable and smooth arc with good slag detachability. 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%	Ni%
0.15 Max	0.50- 1.75	0.80 Max	0.030 Max	0.030 Max	1.00-2.00
Cr%	Mo%				
0.15 Max	.035 Max				

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT -50 °C (J)
620-705 Min	540-590 Min	17-20 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