

ROYALFIL GS 41 R (E91T1-B3 C)

AWS A / SFA 5.29 E90T5-B3 CEN ISO 17634 A TCrMo2BC3H5

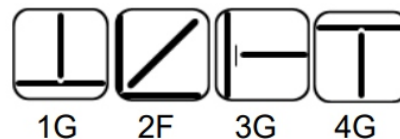
Applications

Royalfil GS-41B3 is designed for welding of creep-resisting 2.25% RoyalFil GS 41R is used for welding of similar composition of Cr-Mo steels and other creep resistant steels. It is also used for welding of high temperature & pipe steels for oil industry and for welding of steel casting (DIN 7245:GS-18CR Mo9-10) Suitable for joining steels conforming to ASTM Grade F22 of SA-182/ SA-182M & SA-336/ SA-336M,Grade

Characteristics on Usage

RoyalFil GS 41R is an all position low alloy rutile base flux cored wire depositing approximately 2.25% Cr & 1.0%Mo weld metal with CO₂ shielding. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for radiography soundness

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%
0.05-0.12	1.25 Max	0.80 Max	0.030 Max	0.030 Max
Cr%	Mo%			
2.00-2.50	0.90-1.20			

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
620-760	540 Min	17.0 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