

# ROYALFIL GS - 413 (E410T0-1)

AWS A /SFA 5.22 EC 409

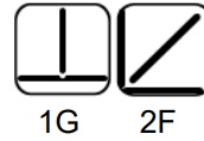
## Applications

Welding of martensite stainless alloys of 13 % Cr type. It is used for surfacing of seraling faces of valves for gas, water & steam piping. Hard surfacing of continuous casting roll of steel plants, valves etc

## Characteristics on Usage

Royal Fil GS - 413 is a martensitic type Gas Shielded flux cored welding wire with 100% Co<sub>2</sub> which are commonly used for hard surfacing of steel mill rolls, valve component of similar alloys. The weld metal is resist to corrosion, erosion or abrasion & resist to high temperature microstructure stability, thermal fatigue & cracking, eliminate ferrite in the microstructure.

## 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%	Cr%
0.12 Max	1.20 Max.	1.00 Max	0.030 Max	0.040 Max	11.00-13.50
NI%	Mo%	Cu%			
0.60 Max	0.75 Max	0.75 Max			

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION. ( L = 4d ) %
520-575 Min	20-24.5 Min

## Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	160-210	26-30
1.60	190-250	26-30

## Packing

15 kgs. Vacuum packed plastic spool