

ROYALFIL GS 42 B (E110T5-K4 C)

AWS A / SFA 5.29 E110T5-K4 C EN ISO 18276 A T695Mn2NiCrMoBC3H5

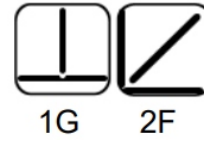
Applications

Royalfil GS-42B is designed for welding of high strength, fine grained quenched & tempered steel like N-A-XTRA 70, USS T1,T1B etc. to meet low temperature toughness as well as down to - 50°C. It is also used for fabrication of earthmoving equipments, steel construction, crane plates and other similar application suitable for joining steels conforming to ASTM Grade C,D of SA-225/SA-225M, Grade A,B,C of SA-738/SA738M, all thickness range OF SA612/612m ETC.

Characteristics on Usage

Royalfil GS-42B is low alloy basic flux cored wire depositing 2% Ni, 0.25% Cr & 0.5% Mo weld metal. The weld deposit is of radiographic quality with very low diffusible hydrogen and stable and smooth arc with good slag detachability. It is used for flat & horizontal welding with CO2 shield

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	1.20-2.25	0.80 Max	0.030 Max	0.030 Max
Cr%	Ni%	Mo%		
0.20-0.60	1.75 - 2.60	0.20 - 0.65		

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)
760-900	680-730 Min	15-20 Min	50-27 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