

# ROYALFIL GS 43 R (E110T1-K4 C)

AWS A /SFA 5.29 E110T1- K4 CEN ISO 18276 A T692Mn2NiCrMoRC3H5

## Applications

It is primarily intended for as welded applications for welding wire low alloy high strength steels. Addition of approximately 0.50Cr provides higher strength for many applications needing in excess of 830 N/ mm<sup>2</sup> tensile strength such as "armour" plate. Typical applications include welding of Hy 100 and ASTM A 514 steels. .

## Characteristics on Usage

RoyalFil GS 43R is Rutile base low hydrogen type flux cored wire designed for single and multiple pass welding in flat and horizontal positions with CO<sub>2</sub> shielding. Weld metal is of radiographic quality.

## 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%
0.15 Max	1.20 -2.25	0.80 Max	0.030 Max	0.030 Max
Cr%	Ni%	Mo%		
2.00-0.65	1.75-2.60	0.20 - 0.65		

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	MPACT(CVN) AT -50 °C ( J )
760-900 Min	680-740 Min	15-20 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